



14" SLIDING TABLE SAW

MODEL G0451

INSTRUCTION MANUAL



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WARNING

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Foreword

We are proud to offer the Model G0451 14" Sliding Table Saw. This machine is part of a growing Grizzly family of fine woodworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G0451. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G0451 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!



Contact Info

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
c/o Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

We stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
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MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G0451 14" Sliding Table Saw

Overall Dimensions:

Overall Size.....105½"D (203⅞" w/Sliding Table Extended) X 117½"W x 49"H
Table Height.....35½"
Table Size (w/Extension Wings) 68" W x 39¾" D
Sliding Table Size 98⅝" W x 13¾" D
Machine Net Weight.....1309 lbs.
Crate Size 102⅞" W x 45½" D x 44½" H
Base Footprint.....54½" W x 39" D

Capacities:

Main Blade Diameter.....12" or 14"
Scoring Blade Diameter.....120mm
Maximum Depth of Cut at 90°.....4⅝"
Maximum Depth of Cut at 45°.....3⅝"
Blade Tilt.....0-45°
Table w/Rip Fence Max Cutting Width.....32⅝"
Sliding Table w/Cross Fence Max Cut Width.....125"
Sliding Table w/Cross Fence Max Cut Length.....98⅝"

Construction:

Sliding Table.....Aluminum
Machine Frame.....Steel
Fence.....Extruded Aluminum
Rails.....Chromed Steel
Trunnions.....Cast Iron
Spindle Ball Bearings.....Sealed and Lubricated

Main Motor:

Arbor.....1"
Arbor Speed.....4200 RPM
Motor.....10 HP, 25/12.5A, 3-Phase, 60 HZ, 220/440V (Prewired 220V)
Motor RPM.....3450
Ball Bearings.....Shielded & Lubricated
Power Transfer.....Belt Drive
Switch.....Magnetic w/Thermal Overload Protection

Scoring Motor:

Arbor.....22mm
Arbor Speed.....8000 RPM
Motor.....1 HP, 3/1.5A, 3-Phase, 60 HZ, 220/440V (Prewired 220V)
Motor RPM.....3450
Ball Bearings.....Shielded & Lubricated
Power Transfer.....Belt Drive

Features:

.....Blade Guard w/2½" Dust Port
.....5" Main Dust Port
.....Adjustable Scoring Knife Kerf
.....Adjustable Riving Knife
.....Micro Adjustable, Single Lever Locking Fence

Specifications, while deemed accurate, are not guaranteed.

Identification

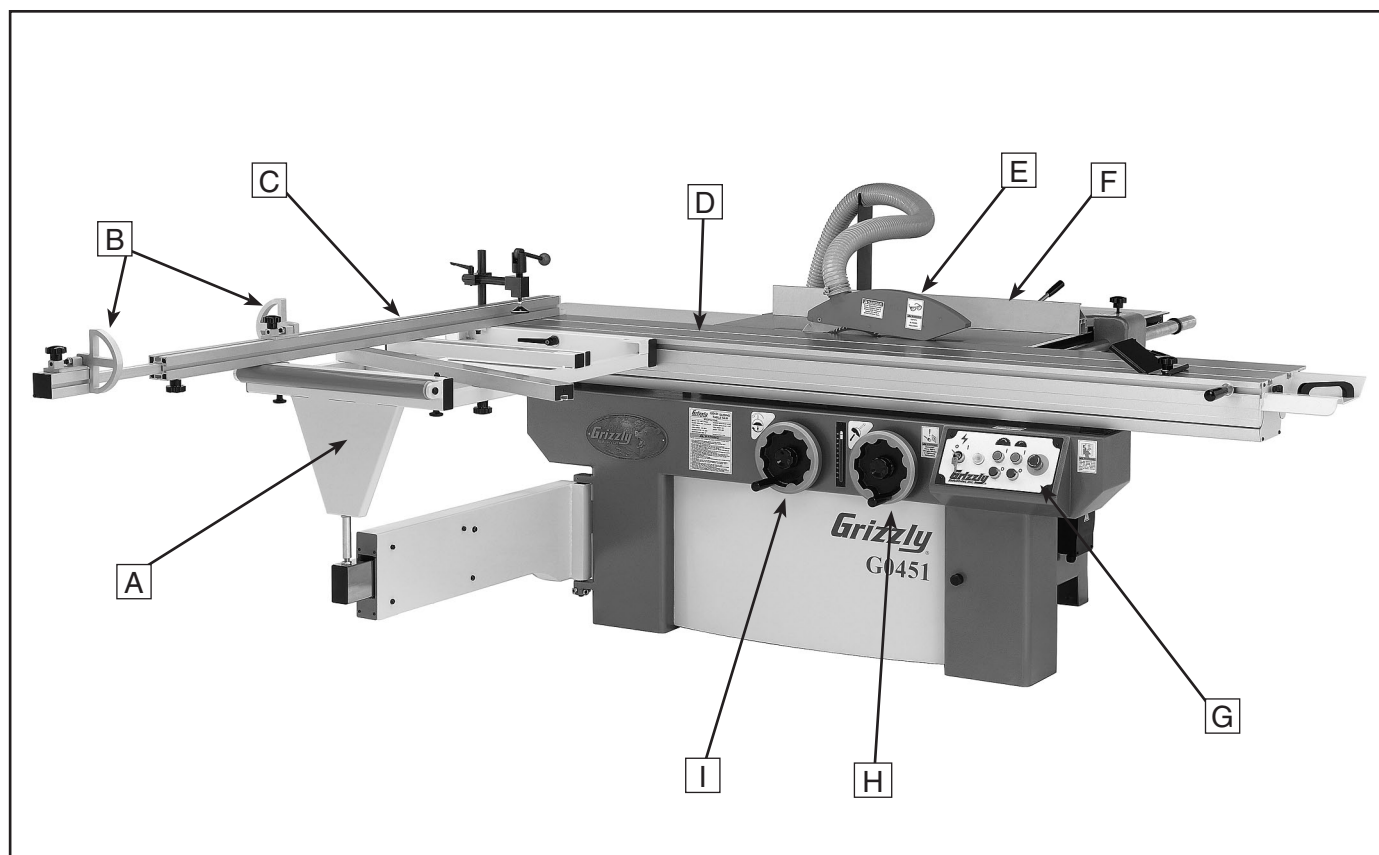


Figure 1. Main view of machine features and controls.

- A. Crosscut Table**—Provides a wide, stable platform for supporting full-size panels during crosscutting operations.
- B. Flip Stops**—Used for quick measurements for crosscutting.
- C. Crosscut Fence**—Used during crosscutting operations. Features a scale and multiple flip-style stop blocks for precise, repeatable crosscutting operations.
- D. Sliding Table**—Conveniently glides the workpiece through the blade with effortless precision and ease.
- E. Blade Guard**—Fully-adjustable blade guard maintains maximum protection around the saw blade and a 2½" dust port effectively extracts dust from the cutting operation.
- F. Rip Fence**—Fully adjustable with micro-adjustment knob for precision adjustments. Fence face can be positioned for standard cutting operations, or in the lower position for blade guard clearance during narrow ripping operations.
- G. Control Panel**—Features push-button controls for operating the many features of the saw.
- H. Blade Angle Handwheel**—Adjusts the angle of the saw blades.
- I. Blade Elevation Handwheel**—Adjusts the height of the main saw blade.

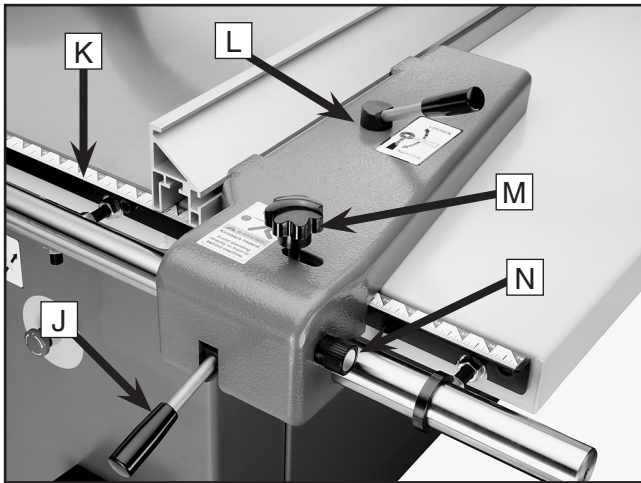


Figure 2. Fence controls.

- J. Fence Assembly Lock Down Lever**—Secures the fence assembly into position along the fence rail.
- K. Rip Fence Scale**—Allows precise measurement of rip cutting operations.
- L. Forward/Backward Slide Lock Handle**—Secures the aluminum fence piece on its forward/backward slide track.
- M. Micro-Adjust Lock Knob**—Secures the fence after it has been adjusted with the micro-adjustment knob.
- N. Micro-Adjust Knob**—Precisely adjusts the fence.

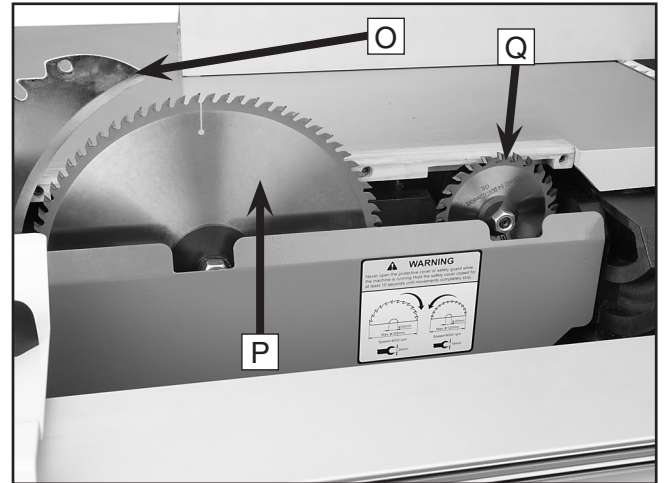


Figure 3. Blades.

- O. Riving Knife**—Maintains kerf opening during cutting operations. This function is crucial to preventing kickback caused by the kerf closing behind the blade.
- P. Main Blade**—Performs the cutting operations.
- Q. Scoring Blade**—Small cutting blade that rotates opposite the main saw blade. The blade scores the workpiece before the actual cutting operation is performed preventing tear-out in laminate materials. The scoring blade is adjustable forward and backward, up and down, and in thickness of kerf.



Figure 4. Control panel close-up.

- R. Power ON/OFF Button**—Connects power to all motors in the saw.
- S. Power Indicator Light**—Indicates a live connection to power.
- T. Main Blade OFF Button**—Stops the main saw blade.
- U. Scoring Blade OFF Button**—Stops the scoring blade.
- V. Primary EMERGENCY STOP Button**—Disconnects power to all motors in the motor cabinet.
- W. Scoring Blade ON Button**—Starts the scoring blade. Note—*The main saw blade must be ON for the scoring blade to start.*
- X. Main Blade ON Button**—Starts the main saw blade.

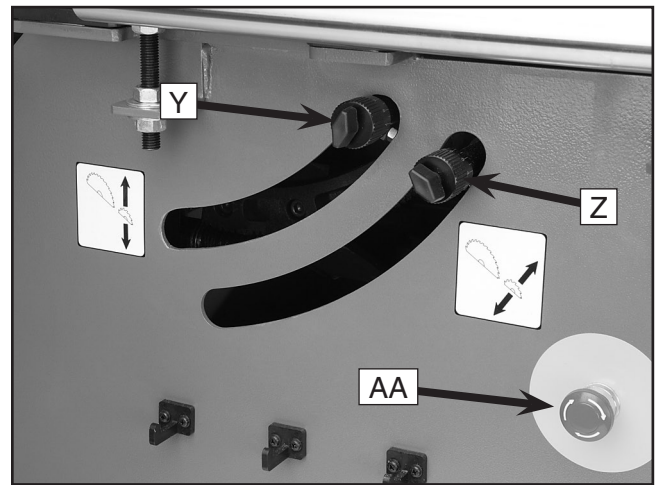


Figure 5. Scoring blade adjustment knobs.

- Y. Scoring Blade Elevation Knob**—Adjusts the height of the scoring blade.
- Z. Scoring Blade Alignment Knob**—Adjusts the alignment of the scoring blade and the main blade.
- AA. Secondary EMERGENCY STOP Button**—Disconnects power to all motors in the motor cabinet.



SECTION 1: SAFETY

WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.



Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the machine.

WARNING

Safety Instructions for Machinery

- 1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 3. ALWAYS WEAR AN ANSI APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Wood dust is a carcinogen and can cause cancer and severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.

WARNING

Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove start switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords overheat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery **ON**.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
23. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
25. **BE AWARE THAT CERTAIN WOODS MAY CAUSE AN ALLERGIC REACTION** in people and animals, especially when exposed to fine dust. Make sure you know what type of wood dust you will be exposed to and always wear an approved respirator.

WARNING

Additional Safety Instructions for Table Saws

1. **SAFETY ACCESSORIES.** Always use the blade guard and riving knife on all "through-sawing" operations. *Through-sawing operations are those when the blade cuts completely through the workpiece.*
2. **KICKBACK.** Be familiar with kickback. Kickback happens when the workpiece is thrown towards the operator at a high rate of speed. *Until you have a clear understanding of kickback and how it occurs, DO NOT operate this table saw!*
3. **WORKPIECE CONTROL.** Make sure the workpiece is placed in a stable position on the table and is either supported by the rip fence or the crosscut table during cutting operations.
4. **PUSH STICK.** Always use a push stick when ripping narrow stock.
5. **OPERATOR POSITION.** Never stand or have any part of your body directly in-line with the cutting path of the saw blade.
6. **AWKWARD OPERATIONS.** Avoid awkward operations and hand positions where a sudden slip could cause your hand to move into the spinning saw blade.
7. **RIVING KNIFE ALIGNMENT.** Only operate the saw if the riving knife is aligned with the main blade.
8. **REACHING OVER SAW BLADE.** Never reach behind or over the blade with either hand while the saw is running. *If kickback occurs while reaching over the blade, hands or arms could be pulled into the spinning saw blade.*
9. **RIP FENCE AND CROSSCUT FENCE USAGE.** When using the crosscut fence, the workpiece should never contact the rip fence while the saw blade is cutting.
10. **STALLED BLADE.** Turn the saw **OFF** before "free-ing" a stalled saw blade.
11. **BLADE HEIGHT.** Always adjust the blade to the proper height above the workpiece.
12. **DAMAGED SAW BLADES.** Never use blades that have been dropped or otherwise damaged.
13. **EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Service Department at (570) 546-9663.

WARNING

Like all machines there is danger associated with the Model G0451. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

WARNING

Statistics prove that most common accidents among table saw users can be linked to kickback. Kickback is typically defined as the high-speed expulsion of stock from the table saw toward its operator. In addition to the danger of the operator or others in the area being struck by the flying stock, the operator's hands can be pulled into the blade during the kickback.

Preventing Kickback

Below are tips to reduce the likelihood of kickback:

- Never attempt freehand cuts. If the workpiece is not fed perfectly parallel with the blade, a kickback will likely occur. Always use the rip fence or crosscut fence to support the workpiece.
- Make sure the riving knife is always aligned with the blade. A misaligned riving knife can cause the workpiece to bind or stop the flow of the cut, resulting in an increased chance of kickback. If you think that your riving knife is not aligned with the blade, check it immediately!
- Ensure that your table slides parallel with the blade; otherwise, the chances of kickback are extreme. Take the time to check and adjust the sliding table.
- Use the riving knife whenever performing a through cut. The riving knife helps maintain the kerf in the workpiece after it is cut, therefore, reducing the chance of kickback.

- Make multiple, shallow passes when performing a non-through cut. Making a deep non-through cut will greatly increase the chance of kickback.
- Feed cuts through to completion. Anytime you stop feeding a workpiece that is in the middle of a cut, the chance of binding, resulting in kickback, is greatly increased.



Protecting Yourself from Kickback

Even if you know how to prevent kickback, it may still happen. Here are some tips to reduce the likelihood of injury if kickback DOES occur:

- Never, for any reason, place your hand behind the blade. Should kickback occur, your hand will be pulled into the blade.
- Stand to the side of the blade during every cut. If a kickback does occur, the thrown workpiece usually travels directly in front of the blade.
- Always wear safety glasses or a face shield. In the event of a kickback, your eyes and face are the most vulnerable part of your body.
- Use a pushstick to keep your hands farther away from the moving blade. If a kickback occurs, the push stick will most likely take the damage that your hand would have received.



Glossary Of Terms

The following is a list of common definitions, terms and phrases used throughout this manual as they relate to this table saw and woodworking in general. Become familiar with these terms for assembling, adjusting or operating this machine. Your safety is **VERY** important to us at Grizzly!

Arbor: Metal shaft extending from the drive mechanism, to which saw blade is mounted.

Bevel Edge Cut: Tilting the arbor and saw blade to an angle between 0° and 45° to cut a beveled edge onto a workpiece.

Blade Guard: Metal or plastic safety device that mounts over the saw blade. Its function is to prevent the operator from coming into contact with the saw blade.

Crosscut: Cutting operation in which the cross-cut fence is used to cut across the grain, or across the shortest width of the workpiece.

Dado Blade: Blade or set of blades that are used to cut grooves and rabbets.

Dado Cut: Cutting operation that uses a dado blade to cut a flat bottomed groove into the face of the workpiece.

Featherboard: Safety device used to keep the workpiece against the rip fence and against the table surface.

Kerf: The resulting cut or gap in the workpiece after the saw blade passes through during a cutting operation.

Kickback: An event in which the workpiece is propelled back towards the operator at a high rate of speed.

Parallel: Being an equal distance apart at every point along two given lines or planes. I.e. the rip fence face is parallel to the face of the saw blade.

Non-Through Cut: A sawing operation that requires the removal of the blade guard and riving knife. Dado and rabbet cuts are considered Non-Through Cuts because the blade does not protrude above the top face of the wood stock. Deep Non-Through Cuts must be made with multiple, light passes to reduce chance of kickback. Always remember to re-install the blade guard and riving knife after performing a non-through cut.

Perpendicular: Lines or planes that intersect and form right angles (i.e. the blade is perpendicular to the table surface).

Push Stick: Safety device used to push the workpiece through a cutting operation. Used most often when rip cutting thin workpieces.

Rabbet: Cutting operation that creates an L-shaped channel along the edge of the workpiece.

Riving Knife (Splitter): Metal plate located behind the blade. It maintains the kerf opening in the wood when performing a cutting operation.

Straightedge: A tool used to check the flatness, parallelism, or consistency of a surface(s).

Through Cut: A sawing operation in which the workpiece is completely sawn through.

Rip Cut: Cutting operation in which the rip fence is used to cut with the grain, or across the widest width of the workpiece.



SECTION 2: CIRCUIT REQUIREMENTS

220/440V 3-Phase

WARNING

Serious personal injury could occur if you connect your machine to the power source before you have completed the set up process. DO NOT connect the machine to the power source until instructed to do so.

Wiring

The Model G0451 is prewired for 220V 3-phase operation. If 440 voltage is required, rewire the machine according to the instructions on **Page 14** and follow the circuit requirements on this page.

Amperage Draw

The Model G0451 has a 10 HP main motor and a 1 HP scoring blade motor; combined they will draw the following amps:

Motor Draw at 220V	28 Amps
Motor Draw at 440V	14 Amps

Minimum Circuit Requirements

Only connect your machine to a circuit that meets the requirements below. Check to see if the wires and circuit breaker in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician.

220V Circuit.....	30 Amp
440V Circuit.....	15 Amp

Minimum Cord Requirements

Use the following type of cord to connect your machine to power (a cord is not provided):

Cord.....	4 wire
Gauge.....	10 Gauge

Connection Type

Because of the high amperage draw from this machine, we recommend that you hardwire it directly to your circuit breaker and install a locking shut-off lever (see **Figure 6**) near the machine as a way to quickly disconnect the power and prevent accidental starting.

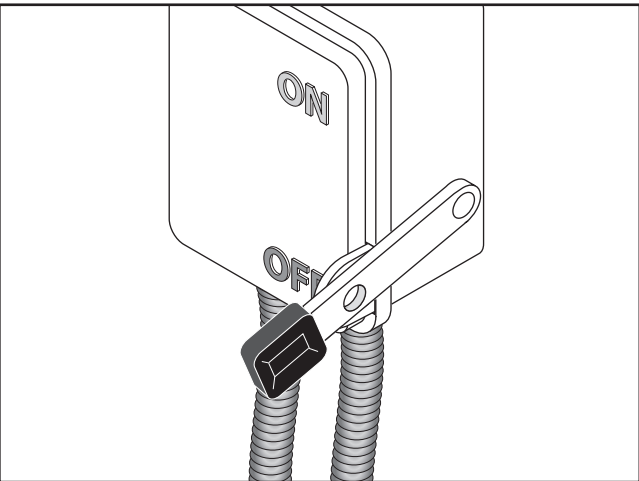


Figure 6. A power disconnect is preferable to high current plugs and receptacles.

CAUTION

A fire may occur if your particular electrical configuration does not comply with local and state codes. The best way to ensure compliance is to check with your local municipality or a qualified electrician.



Phase Converter

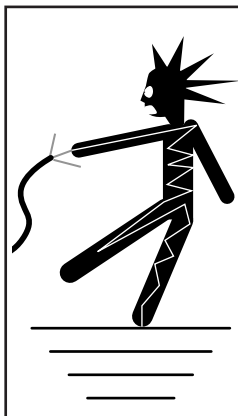
When using a phase converter, the power from the manufactured power leg (sometimes called the wild wire) can fluctuate. Connect the manufactured power leg to the S terminal to prevent damage to the transformer. The wire from the S terminal can handle some fluctuation because it goes directly to the motor. The power going to the R and T terminals goes to the transformer and must be consistent to prevent damage. See the phase converter instruction manual for more information.



Grounding

In the event of an electrical short, grounding reduces the risk of electric shock. This tool is equipped with a power cord that has a grounding wire, which must be properly connected to the grounding prong on the plug; likewise, the outlet must be properly installed and grounded. All electrical connections must be made in accordance with local codes and ordinances.

Improper connections of the electrical-grounding conductor increases the risk of electric shock. Check with a qualified electrician or one of our service personnel if you do not understand the grounding instructions, or if you doubt the machine is properly grounded.



!WARNING

Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. Ensure compliance by checking with a qualified electrician!



Rewiring to 440V

The Model G0451 can be rewired for 440V operation. This rewiring job consists of disconnecting the saw from the power source, changing the connections on the voltage transformer, changing the overload relays for the scoring motor, and rewiring the cutting motor and scoring motor.

The necessary overload relay for this procedure can be purchased by calling our customer service number at (800) 523-4777 and ordering part number P04510014A.

This procedure takes moderate electrical skill and the rewiring job must be inspected by a qualified electrician before the saw is connected to the power source. Also, the motors can be accessed easier for rewiring if the blade is moved to 0° (90° to table) before beginning.

To rewire the Model G0451 for 440V operation:

1. **Disconnect the saw from the power source!**
2. Open the electrical panel and locate the voltage transformer shown in **Figure 7**.

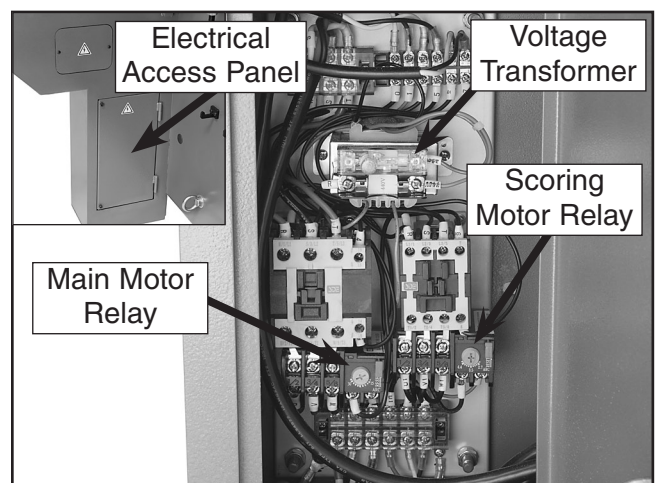


Figure 7. Inside view of the control panel.

3. At the voltage transformer, pull the fuse that is in the “220” slot and push it into the “440” slot (see **Figure 8**).

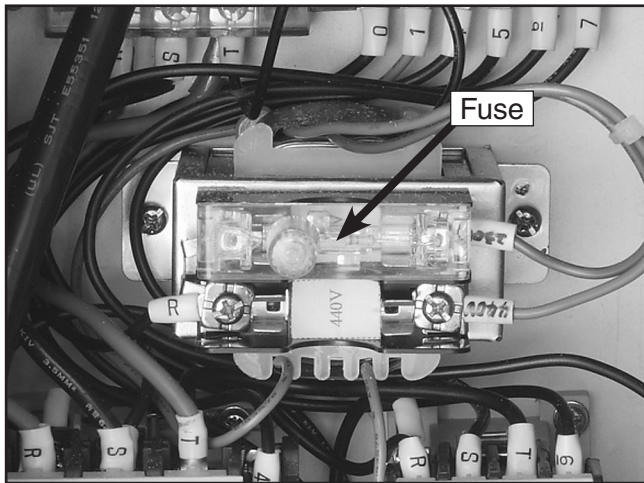


Figure 8. Fuse installed at the 220V location.

4. Turn the dial (**Figure 9**) on the main motor overload relay to 15A.

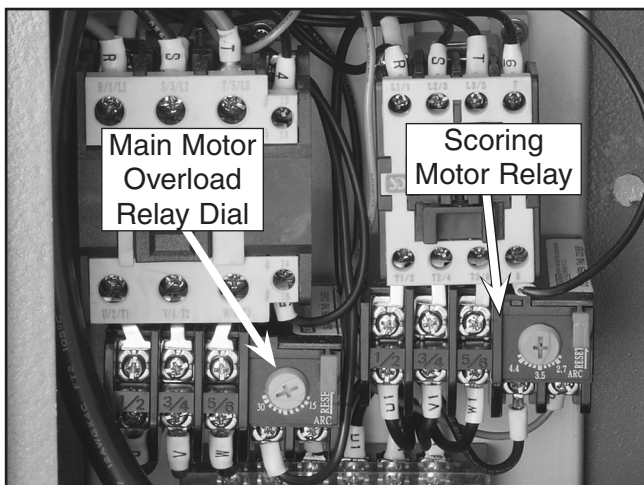


Figure 9. Motor overload relays.

5. Remove the scoring motor overload relay and replace it with the 440V overload relay. Set the overload relay dial to 2A.

6. Open the motor cabinet door and remove the motor wiring covers from the main motor and the scoring motor (see **Figure 10**).

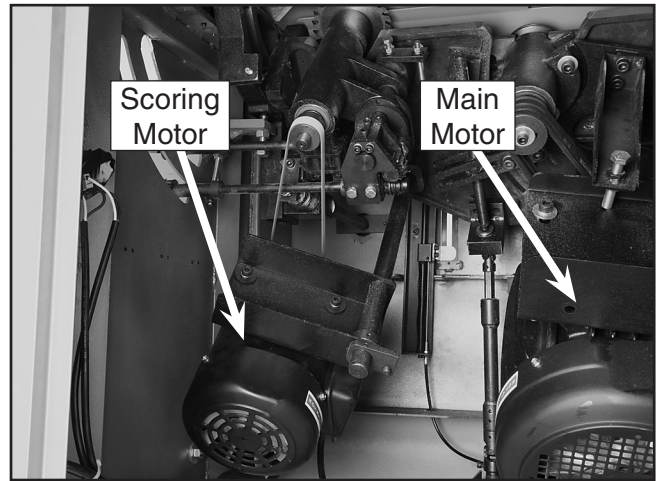


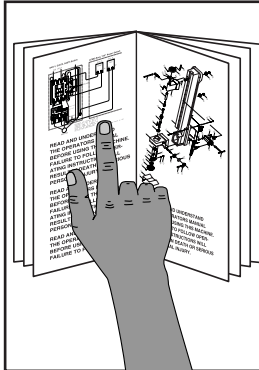
Figure 10. Motor locations.

7. Rewire the motors as shown on the diagrams that are placed on the inside of the motor wiring covers.



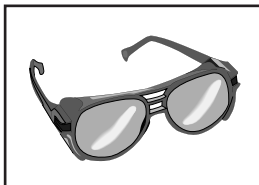
SECTION 3: SET UP

Set Up Safety



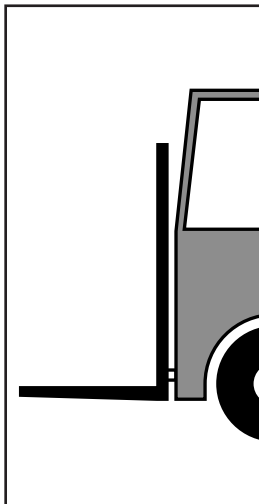
!WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



!WARNING

Wear safety glasses during the entire set up process!



!WARNING

The Model G0451 is a heavy machine that weighs over 1300 lbs. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and power equipment when moving the shipping crate and removing the machine from the crate.



Unpacking

The Model G0451 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the contents.



Items Needed For Set Up

The following items are needed to complete the set up process, but are not included with your machine:

Description	Qty
• Safety Glasses (for each person)	1
• Power Lifting Equipment	1
• Lifting Straps (1500 lb capacity).....	2
• An Assistant	1
• Straightedge 4' (or longer)	1
• Main Blade 12" or 14"	1
• Phillips Head Screwdriver	1
• Hex Wrenches 3, 4, 6, & 8mm.....	1 Each
• Wrenches or Sockets, 16 & 18mm ...	1 Each
• Dust Collection System	1
• 5" Dust Hose (length as needed)	1
• 5" Hose Clamp	2
• 2½" Dust Hose (length as needed)	1
• Power Cord (length as needed)	1
• Power Disconnect Box	1



Inventory

After all the parts have been removed from the boxes, you should have the following items:

Box 1: (Figure 11)	Qty
A. Support Brace	1
B. Small Extension Table	1
C. Large Extension Table	1

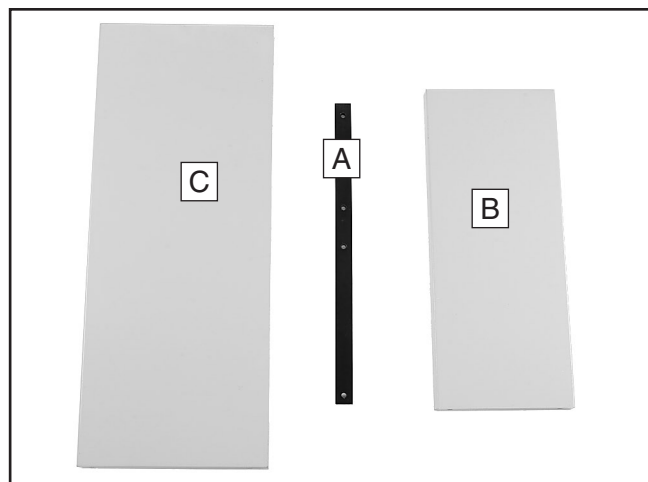


Figure 11. Box 1 contents.

Box 2 & 3: (Figure 12)	Qty
D. Crosscut Fence	1
E. Rip Fence Round Rail	1
F. Crosscut Table Brace	1
G. Rip Fence Scale	1
H. Rip Fence	1

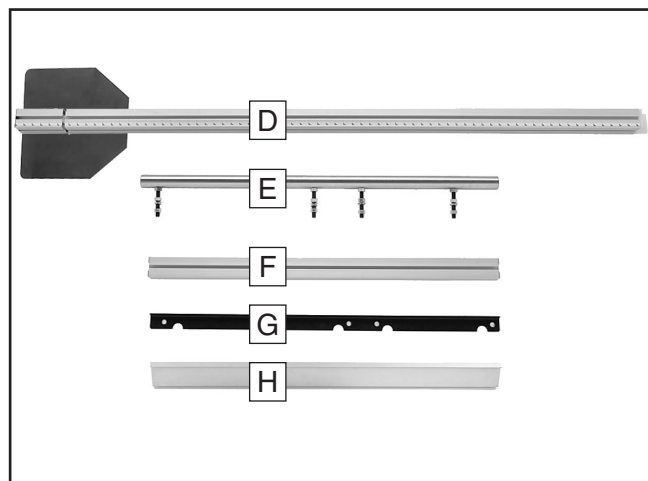


Figure 12. Box 2 & 3 contents.

Box 4: (Figure 13)	Qty
I. Crosscut Table	1

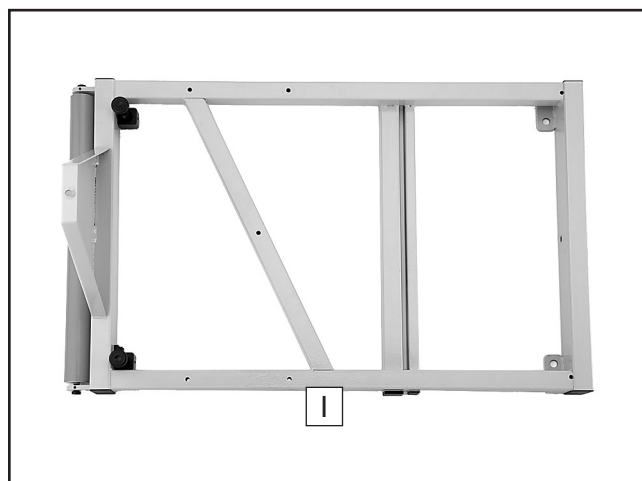


Figure 13. Box 4 contents.

Box 5: (Figure 14)	Qty
J. Sliding Table End Handle	1
K. Sliding Table Lock Plate	1

Box 6: (Figure 14)	Qty
L. Flip Stops	2
M. Edge Shoe	1
N. Hold Down	1

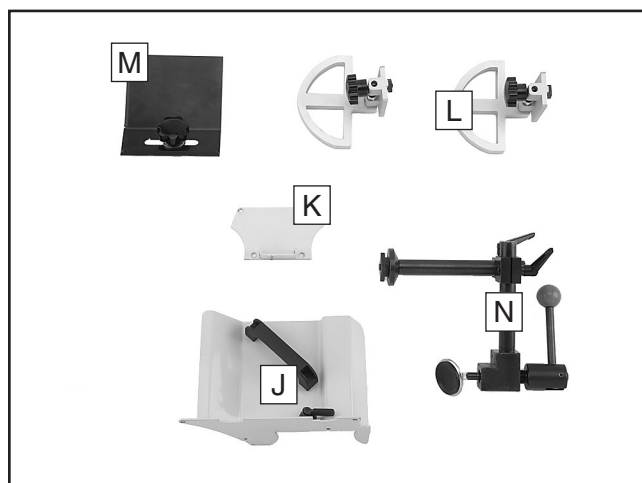


Figure 14. Box 5 & 6 contents.

Box 7: (Figure 15)		Qty
O.	Rip Fence Body.....	1
P.	Blade Guard/Dust Hood.....	1
Q.	Push Stick	1
R.	Dust Collection Hose Support.....	1



Figure 15. Box 7 contents.

Box 7 Cont.: (Figure 16)		Qty
S.	Toolbox	1
	— Flat Belt 15 x 787mm	1
	— Riving Knife	1
	— Arbor Wrenches.....	2
	— Hose Clamps 2½"	2

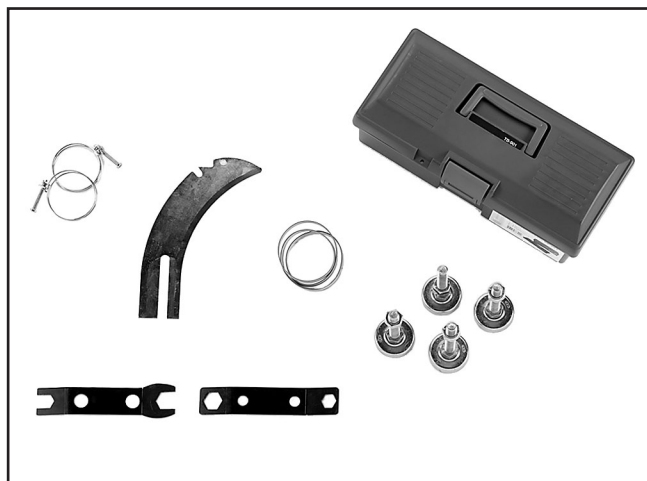


Figure 16. Box 7 contents continued.

Box 7 Cont.:		Qty
S.	Toolbox Cont.	
	— Hardware	1
	• Cap Screw M10-1.5 x 30.....	4
	• Cap Screw M10-1.5 x 20.....	10
	• Hex Nut M10-1.5	4
	• Lock Washer 10mm.....	14
	• Flat Washer 10mm	10
	• Set Screw M6-1.0 x 12.....	6
	• Stud M12-1.75 x 115.....	4
	• Hex Nut M12-1.75	12
	• Flat Washer 12mm	10
	• Lock Washer 12mm.....	4
	• Lock Washer 8mm.....	1
	• Cap Screw M8-1.25 x 16	1
	• End Washer 8mm	1
	• Adjustable Ring & Set Screw.....	1
	• Center Stud M8-1.25 x 10	1
	• Fiber Washer 8mm	1
	• T-Nut M8-1.25	2
	• T-Nut M12-1.75.....	2
	• Handle M12-1.75 x 12	1
	• Adjustable Handle M12-1.75 x 55	1
	• Handle M10-1.5 x 12	2
	• Knob M10-1.5 x 70.....	1
	• Knob M8-1.25 x 25	1
	• Knob M8-1.25 x 50	2
	• Knob M8-1.25	1
	• T-Bolt M8-1.25 x 60	1
	• Flat Washer 8mm	3
	• Feet M16-2.0 x 100.....	4

In the event that any nonproprietary parts are missing (e.g. a nut or a washer), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.



Hardware Recognition Chart

USE THIS CHART TO MATCH UP
HARDWARE DURING THE ASSEMBLY
PROCESS!

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

○ #10

○ 1/4"

○ 5/16"

○ 3/8"

○ 7/16"

○ 1/2"

○ 4mm

○ 6mm

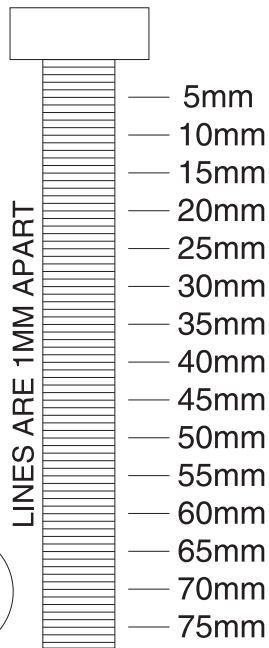
○ 8mm

○ 10mm

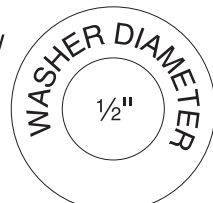
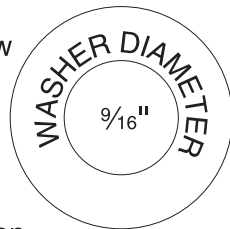
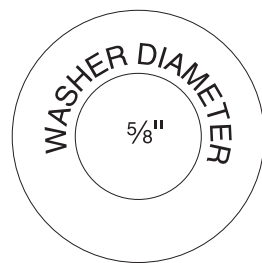
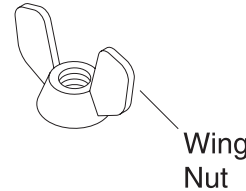
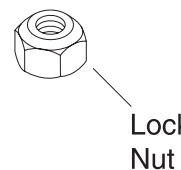
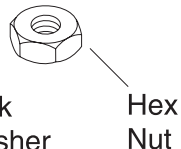
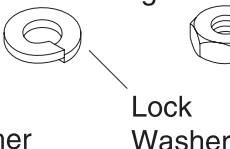
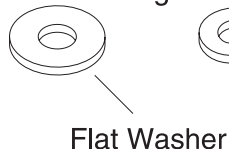
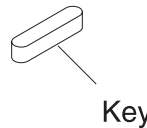
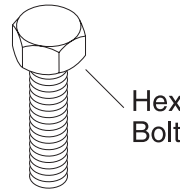
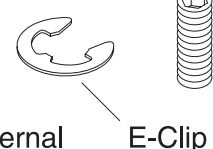
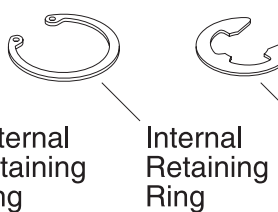
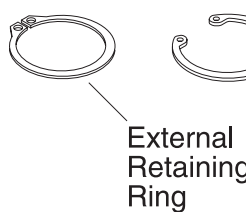
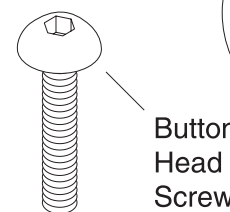
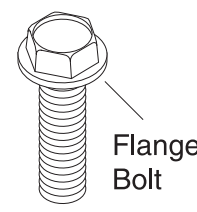
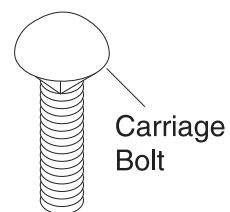
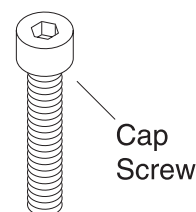
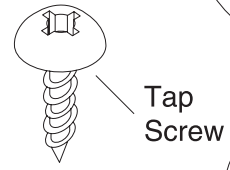
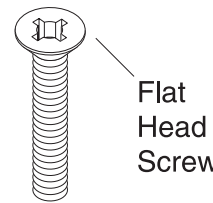
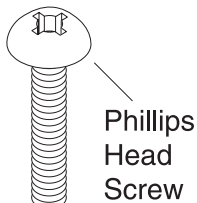
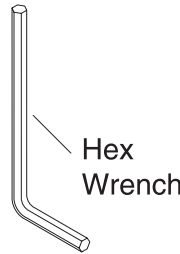
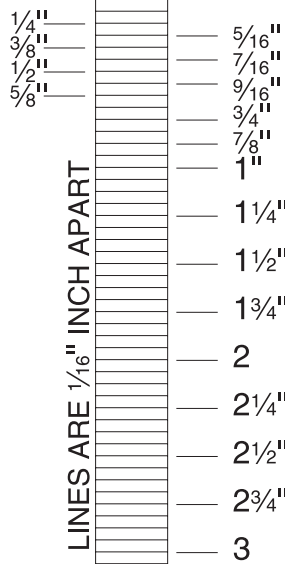
○ 12mm

○ 16mm

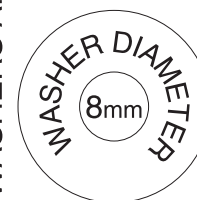
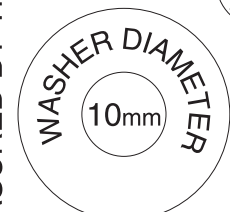
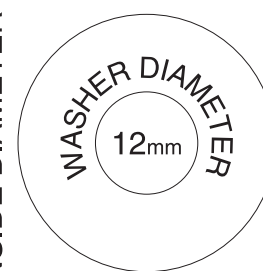
LINES ARE 1MM APART



LINES ARE 1/16" INCH APART

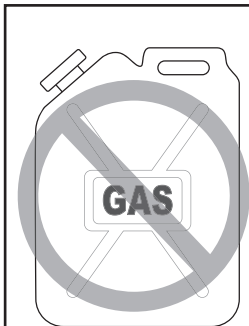


WASHERS ARE MEASURED BY THE INSIDE DIAMETER



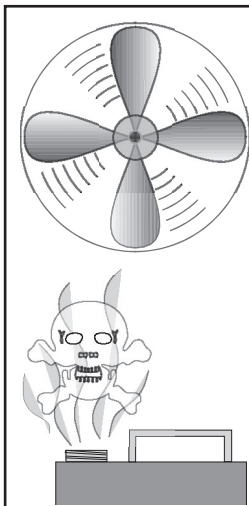
Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner, as they may damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.



⚠️ WARNING

Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. **DO NOT** use gasoline or petroleum products to clean the machinery.



⚠️ CAUTION

Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.



Site Considerations

Floor Load

The Model G0451 weighs 1309 lbs. and has a base footprint of 54½" W x 39" D. Most commercial floors are suitable for your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Working Clearances

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your saw. See **Figure 17** for the maximum working clearances of the Model G0451.

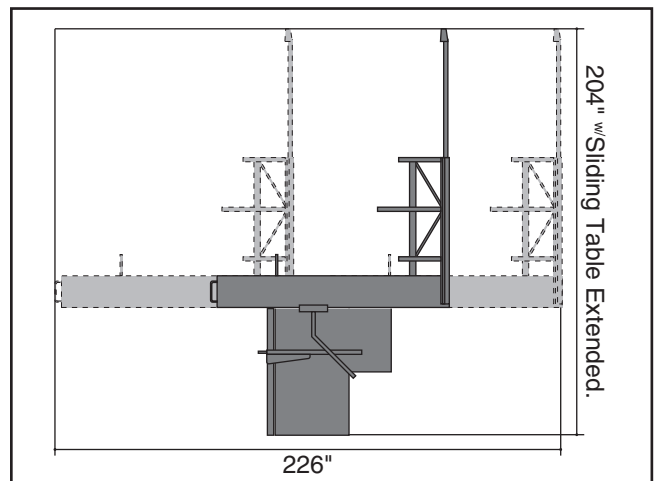
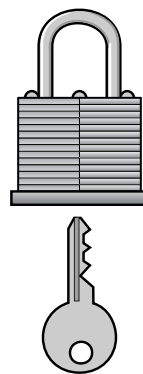


Figure 17. Working clearances.

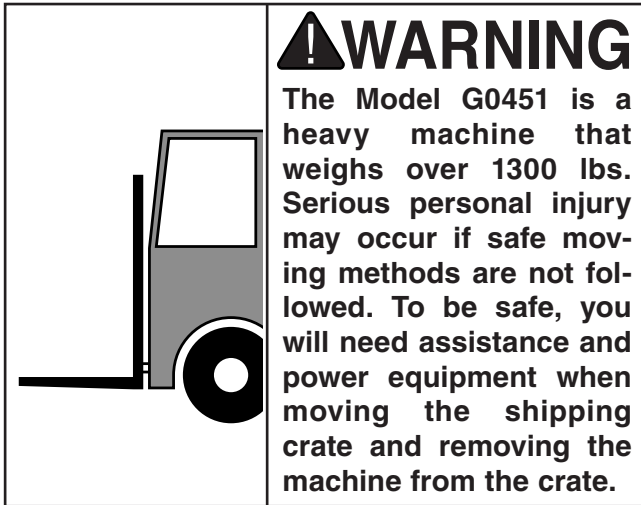


⚠️ CAUTION

Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and **DO NOT** allow unsupervised children or visitors in your shop at any time!



Moving & Placing Base Unit



!WARNING

Use lifting straps with a minimum of 1500 lbs. lifting capacity. If the lifting strap breaks, serious personal injury may occur.

To remove the saw base unit from the crate pallet:

1. Remove the top of the crate and position the forklift forks together and directly above the saw.
2. Place two lifting straps over the forks and attach the ends to the lifting bolts as shown in **Figure 18**.

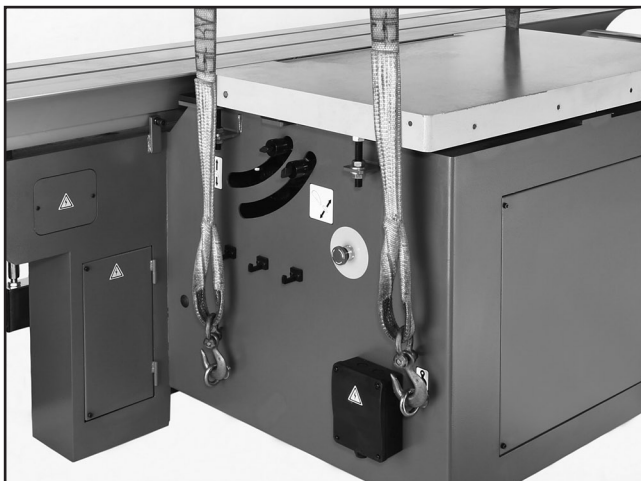


Figure 18. Lifting the saw base unit.

!WARNING

DO NOT lift the table saw any higher than necessary to clear the floor. Serious personal injury and damage to the machine may occur if safe moving methods are not followed.

3. Lift the saw base unit and move it to your predetermined location.
4. Before lowering the saw into position, place safety blocks under the frame and thread the four foot studs into the frame at least half of their length.
5. Remove the safety blocks and lower the saw onto the feet as shown in **Figure 19** and remove the forklift straps.



Figure 19. Foot studs placed in base feet.

6. Place a level on the saw table and adjust foot studs so the saw table is level from left-to-right and from front-to-back. This will allow the table to slide smoothly.
7. Lock the foot studs in position by tightening their jam nuts against the machine body.



Extension Tables

Components and Hardware Needed:	Qty
Large Extension Table	1
Small Extension Table.....	1
Support Brace	1
Dust Collection Hose Support.....	1
Cap Screws M10-1.5 x 30.....	4
Cap Screws M10-1.5 x 20.....	6
Hex Nuts M10-1.5	2
Lock Washers 10mm.....	10
Flat Washers 10mm	6
Set Screws M6-1 x 12.....	6

Tools Needed:	Qty
An Assistant	1
Hex Wrench 3mm.....	1
Hex Wrench 8mm.....	1
Socket or Wrench 16mm.....	1
Straightedge 4' (or longer).....	1

To install the extension tables:

1. Thread the set screws into the small holes in both extension tables. Make sure the set screws do not stick out from the mating surface.

Note—Do not completely tighten the bolts in the following steps until the tables are leveled.

2. Attach the small extension table with two M10-1.5 x 20 cap screws, lock washers, and flat washers as shown in **Figure 20**. *Note—Get assistance positioning the tables and holding them in place while installing.*

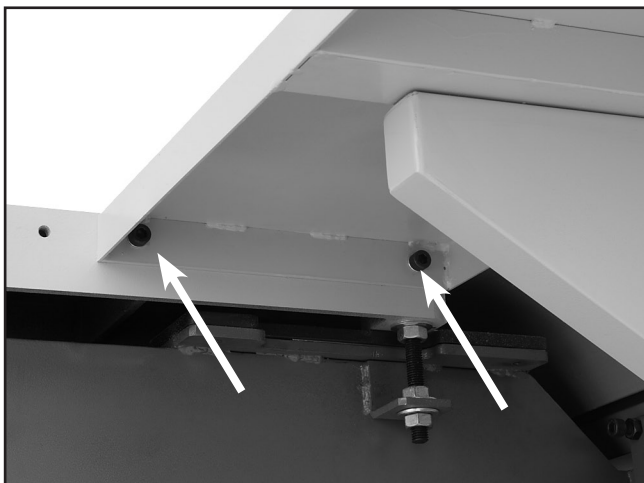


Figure 20. Small extension table attachment.

3. Attach the large extension table with four M10-1.5 x 20 cap screws, lock washers, and flat washers as shown in **Figure 21**.



Figure 21. Large extension table attachment.

4. Attach the support brace (**Figure 22**) to the table with two M10-1.5 x 30 cap screws and lock washers. *Note—Do not attach the brace to the extension table until the next step.*

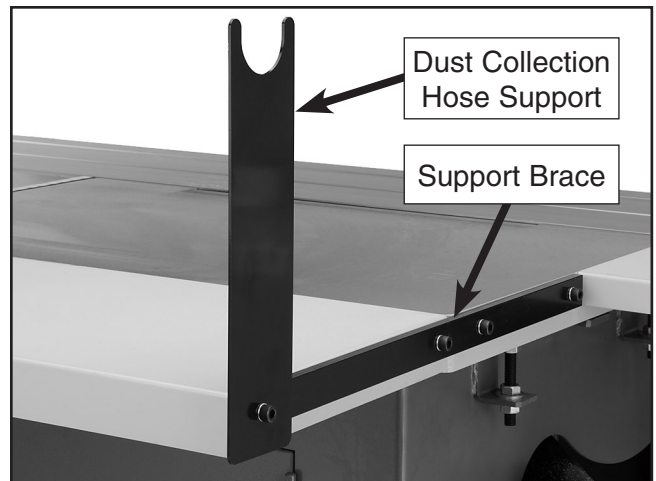


Figure 22. Support brace and dust collection hose support installation.

5. Place the dust collection hose support over the support brace as shown in **Figure 22** and thread M10-1.5 x 30 cap screws with lock washers through the remaining support brace holes and secure with hex nuts.

- 6. Check the surfaces of the table with a straightedge as shown in **Figure 23**.



Figure 23. Checking with a straightedge.

- 7. Use the set screws under both extension tables to level the top surfaces with the saw table.
- 8. When the surfaces are level, thread the bolt shown in **Figure 24** against the underside of the small extension table to hold it level.

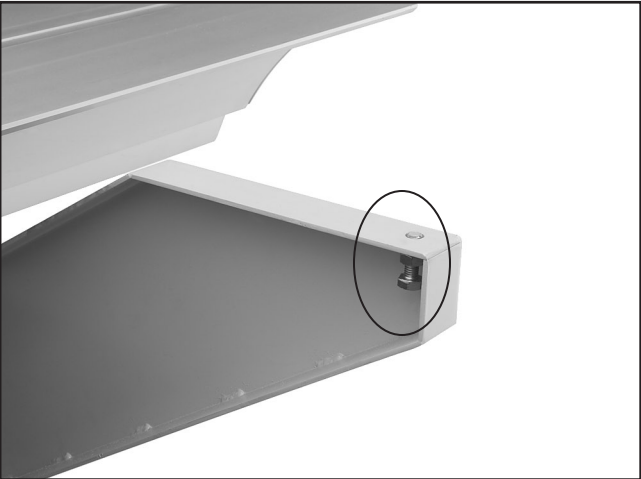


Figure 24. Small extension table support bolt.

- 9. Tighten all of the cap screws securing the tables.



Scale

Components and Hardware Needed:		Qty
Rip Fence Scale		1
Cap Screws M10-1.5 x 20.....		4
Hex Nuts M10-1.5		2
Lock Washers 10mm.....		4
Flat Washers 10mm		4

Tools Needed:		Qty
Hex Wrench 8mm.....		1
Socket or Wrench 16mm.....		1

To install the scale:

- 1. Loosely thread four M10-1.5 x 20 cap screws with lock and flat washers through the scale and into the table as shown in **Figure 25**.



Figure 25. Attaching the scale.

- 2. Secure the cap screws to the extension table with M10-1.5 hex nuts, but do not fully tighten.
- 3. Line the scale up with the top of the table and tighten the cap screws.



Rip Fence

Components and Hardware Needed:	Qty
Rip Fence	1
Rip Fence Round Rail	1
Rip Fence Body	1
Stud M12-1.75 x 115	4
Hex Nut M12-1.75	12
Flat Washer 12mm	8
Lock Washer 12mm	4
Lock Washer 8mm	1
Cap Screw M8-1.25 x 16	1
End Washer 8mm	1
Adjustable Ring & Set Screw	1
Lock Handle M10-1.5 x 12	2
Knob M10-1.5 x 70	1

Tools Needed:	Qty
Hex Wrench 3mm	1
Socket or Wrench 18mm	1

To install the rip fence:

1. Thread four M12-1.75 x 115 studs into the round rail.
2. Thread an M12-1.75 hex nut onto each stud and tighten the nuts against the round rail.
3. Thread an M12-1.75 hex nut and a flat washer half way onto each stud.
4. Insert the studs into the table as shown in **Figure 26**. Loosely secure with an M12-1.75 hex nut, lock washer, and a flat washer on each stud.



Figure 26. Installing the round rail.

5. Slide the rip fence body onto the rail, then place the adjustable ring on the sliding table end of the rail and secure the ring with the set screw as shown in **Figure 27**.



Figure 27. Securing the adjustable ring.

6. Thread the lock handles (**Figure 28**) into the rip fence body and loosely install the fine adjustment knob.

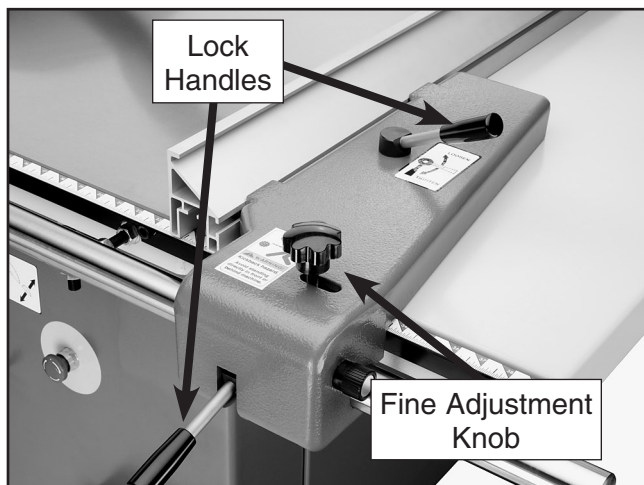


Figure 28. Rip fence handles.

7. Place the end washer on the end of the rip fence rail and secure it with the M8-1.25 cap screw and lock washer.

8. Slide the aluminum rip fence onto the clamping plate as shown in **Figure 29** and lock it with the handle on top of the rip fence body.

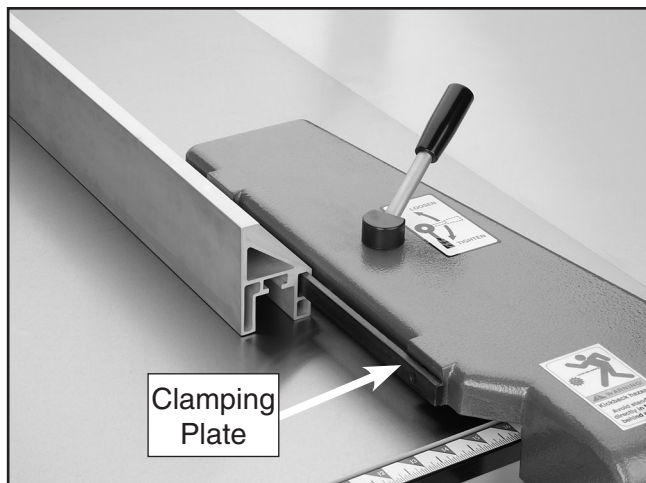


Figure 29. Installing the rip fence.

9. Adjust the nuts on the outside of the table until the edge of the rip fence is parallel with the sliding table as shown in **Figure 30**.

Note—Adjust the nut closest to the sliding table so the rip fence slides freely, leave the center two nuts loose, and adjust the outside nut until the rip fence is parallel with the sliding table.

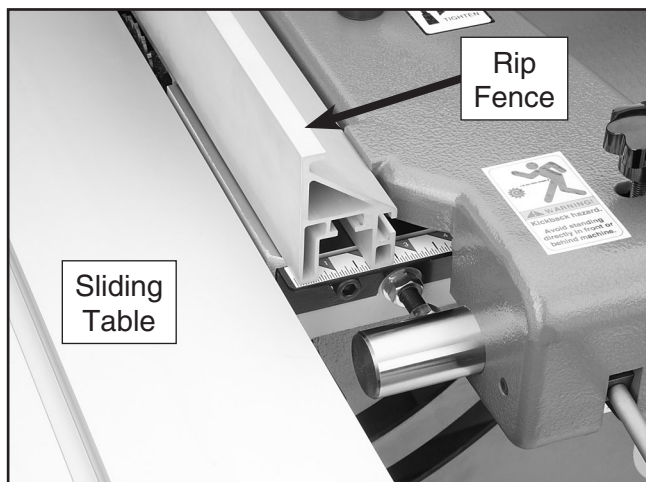


Figure 30. Aligning the fence with the edge of the sliding table.

10. Check the height of the rip fence rail by sliding the rip fence along the rail and comparing the gap between the rip fence body and the table.

11. Adjust the height of the rip fence rail, then tighten all of the nuts against the table as shown in **Figure 31**.



Figure 31. Rip fence rail adjustment nuts.

12. Check if the bottom of the rip fence rests on the surface of the table. Note—*The rip fence will scratch the table surface if the ride height is not adjusted correctly.*

—If the rip fence **does not** rest on the table, then the fence is correctly adjusted.

—If the rip fence **does** rest on the table, loosen the set screw shown in **Figure 32** and rotate the hex bolt to raise the roller. Tighten the set screw to lock the ride height.

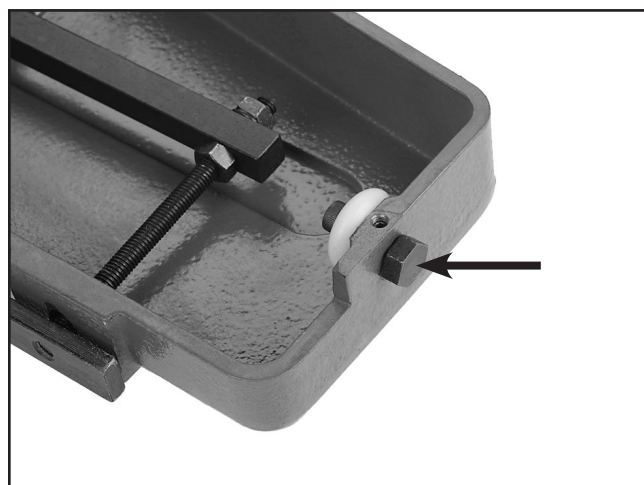


Figure 32. Rip fence height adjustment.



Crosscut Table

Components and Hardware Needed:	Qty
Crosscut Table	1
Crosscut Table Brace	1
T-Nut M8-1.25.....	2
T-Nut M12-1.75.....	1
Flat Washer 12mm	1
Adjustable Handle M12-1.75 x 55	1
Knob M8-1.25 x 50	2
Flat Washer 8mm	2

Tools Needed:	Qty
An Assistant	1

To install the crosscut table:

1. Thread the M12-1.75 x 55 adjustable handle, with a 12mm flat washer, through the crosscut table and into a M12-1.75 T-nut as shown in **Figure 33**.

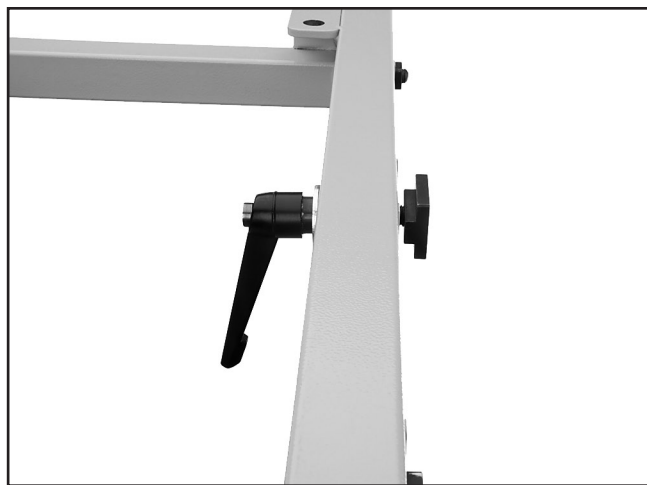


Figure 33. Installing the adjustable handle.

2. With the help of an assistant, place the crosscut table on the pivot pin of the swing arm and slide the T-nut into the T-slot in the sliding table (see **Figure 34**).

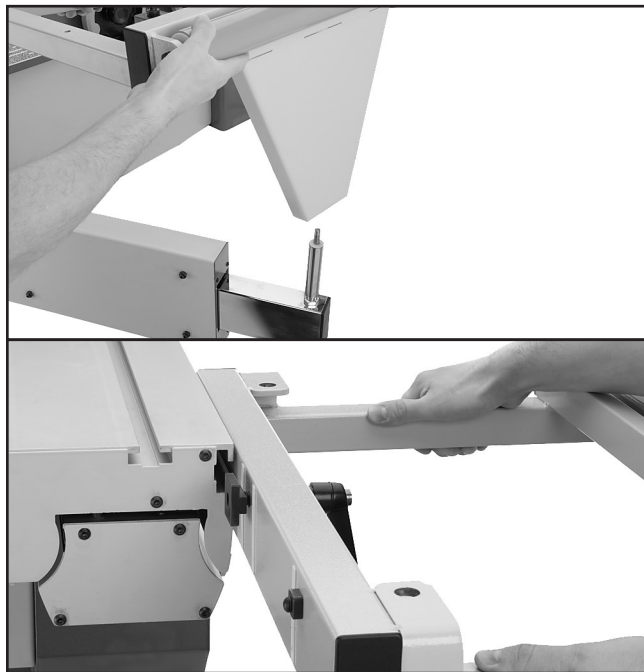


Figure 34. Installing the crosscut table.

3. Slide two M8-1.25 T-nuts into the crosscut table brace.
4. Align the T-nuts in the crosscut table brace with the holes in the crosscut table and thread the M8-1.25 x 50 knobs, with 8mm flat washers, into the T-nuts as shown in **Figure 35**.

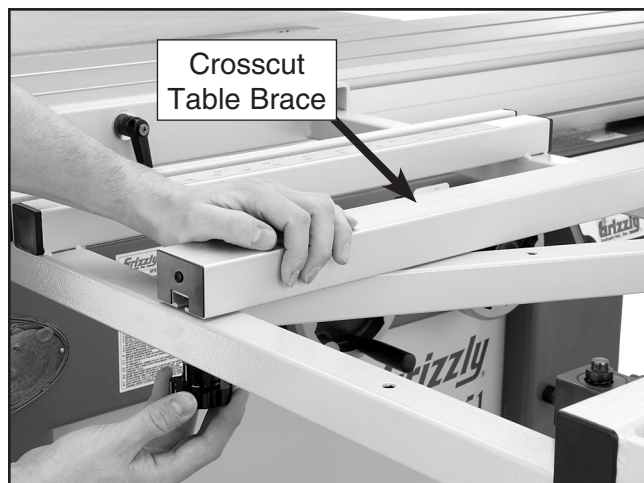


Figure 35. Installing the crosscut table brace.



Crosscut Fence

Components and Hardware Needed:		Qty
Crosscut Fence		1
Center Stud M8-1.25 x 10		1
Fiber Washer 8mm		1
T-Nut M8-1.25		1
Knob M8-1.25 x 25		1
Knob M8-1.25		1
T-Bolt M8-1.25 x 60		1
Flat Washer 8mm		1

Tools Needed:		Qty
Hex Wrench 6mm		1

To install the crosscut fence:

1. Thread the center stud and the fiber washer into the remaining M8-1.25 T-nut.
2. Slide the center stud, an M8-1.25 x 60 T-bolt, and screw a M8-1.25 x 25 knob into the crosscut fence as shown in **Figure 36**.

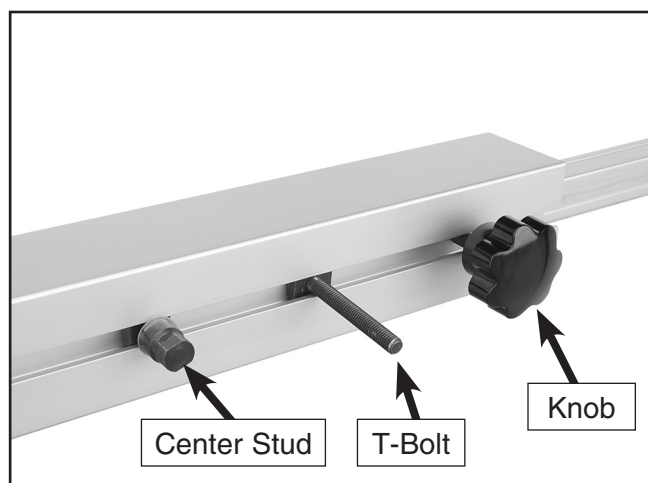


Figure 36. Crosscut fence assembly.

3. Slide the center stud to the end with the plastic cap and tighten it in place.

4. Insert the center stud and the T-bolt in the places indicated in **Figure 37**.

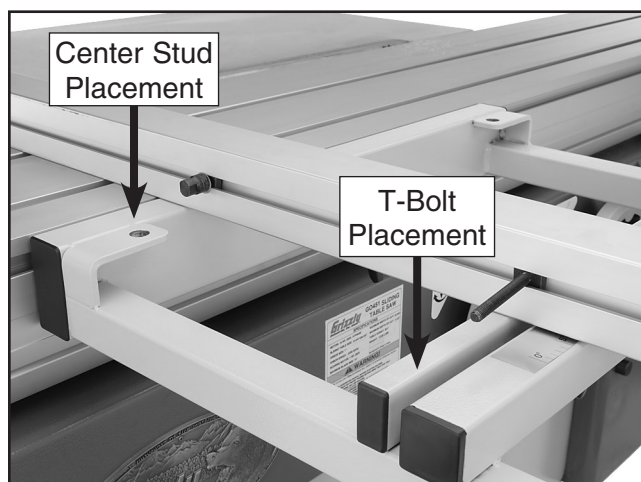


Figure 37. Crosscut fence placement.

5. Secure the crosscut fence with the M8-1.25 knob with an 8mm flat washer threaded onto the T-bolt.
6. Unlock the crosscut fence extension and slide the flip stops into the fence as shown in **Figure 38**.

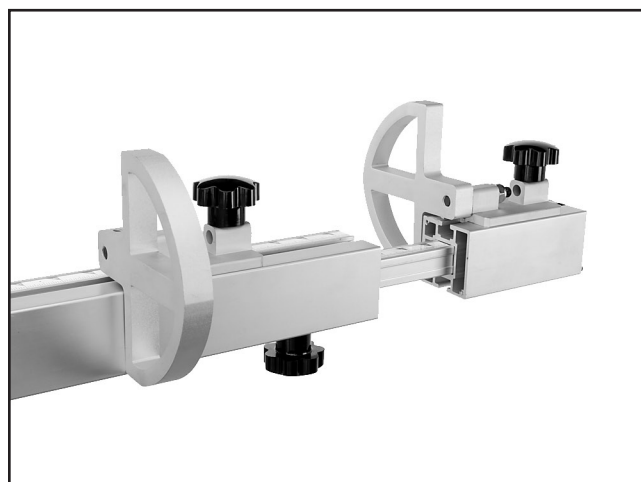


Figure 38. Stop block installation.



Sliding Table

Components and Hardware Needed:	QTY
T-Nut M12-1.75.....	1
Flat Washer 12mm	1
Push Handle M12-1.75 x 12.....	1
Edge Shoe.....	1
Hold Down.....	1
Sliding Table End Handle.....	1
Sliding Table Lock Plate.....	1

Tools Needed:	QTY
Hex Wrench 4mm.....	1

To assemble the sliding table components:

1. Remove the red shipping brace (**Figure 39**) and the screws indicated. Set the screws aside for use in the following steps.

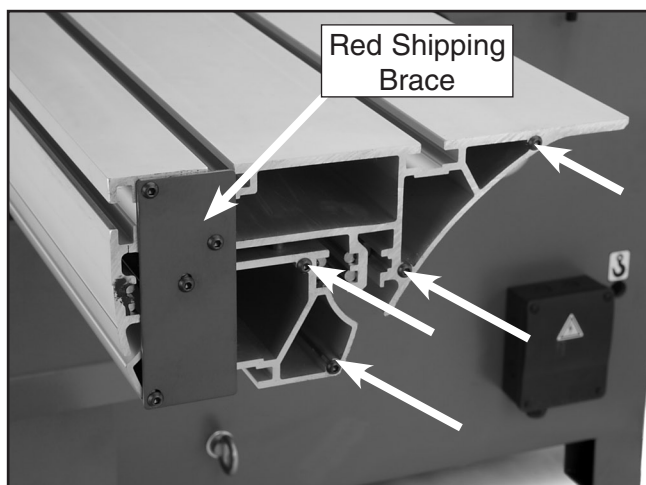


Figure 39. Sliding table.

2. Install the lock plate as shown in **Figure 40** using 4 of the screws removed in the previous step.

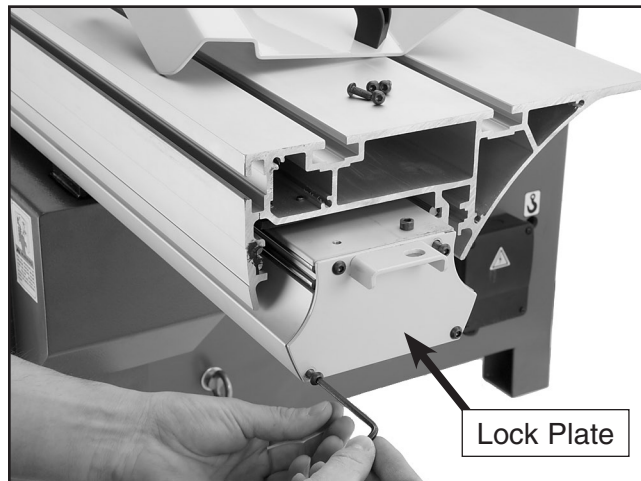


Figure 40. Installing the lock plate.

3. Install the end handle, as shown in **Figure 41**, using the remaining screws removed in Step 1.

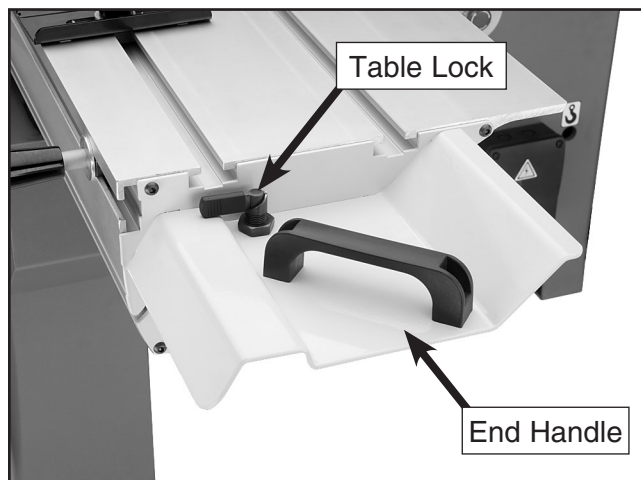


Figure 41. Sliding table end handle.

4. The sliding table is locked in place when the table lock is in the position shown in **Figure 41**. Rotate the table lock 180° to unlock the sliding table.

- Slide the M12-1.75 T-nut into the sliding table and thread in the M12-1.75 x 12 push handle with a washer as shown in **Figure 42**.

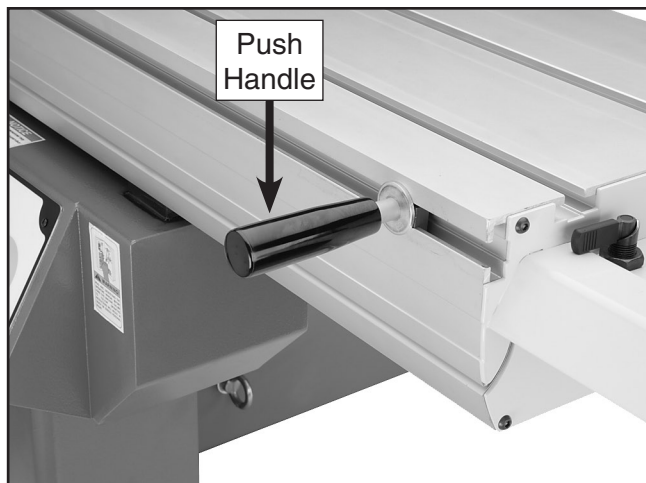


Figure 42. Sliding table push handle.

- Slide the edge shoe into the table as shown in **Figure 43** when needed.

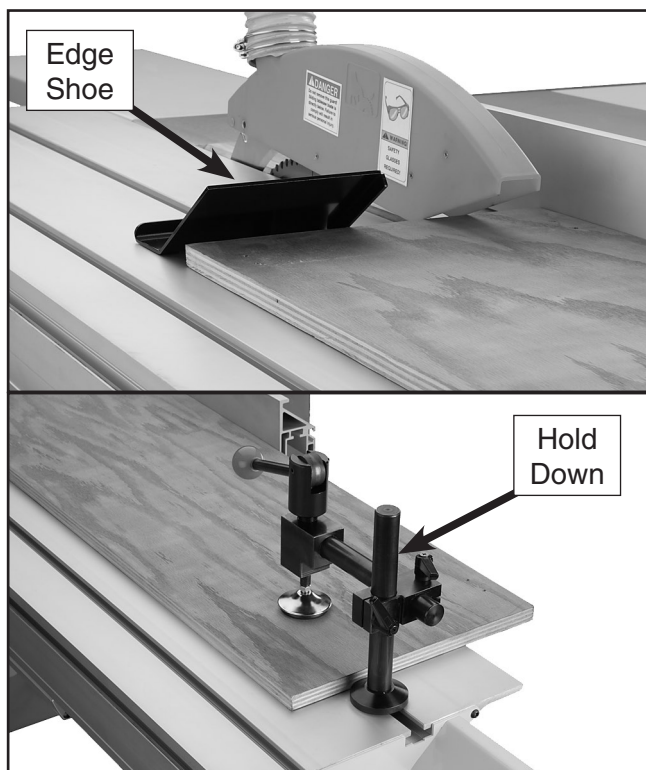


Figure 43. Edge shoe and hold down placement.

- Slide the hold down onto the table when needed and lock it in place as shown in **Figure 43**.



Main Blade

The Model G0451 is designed to accommodate either a 12" or a 14" main blade. But any time you change blade sizes, the riving knife must be adjusted to match the size of blade you install.

Components and Hardware Needed:	Qty
Blade 12" or 14" (Not Included)	1
Flat Belt 15 x 915mm	1
Riving Knife	1

Tools Needed:	
Arbor Wrenches	2

To install the blade:

- Open the motor compartment and remove the red shipping brackets from both motors.
- Place the flat belt on the scoring blade arbor as shown in **Figure 44**, lift the scoring motor, and slide the flat belt over the scoring motor pulley.

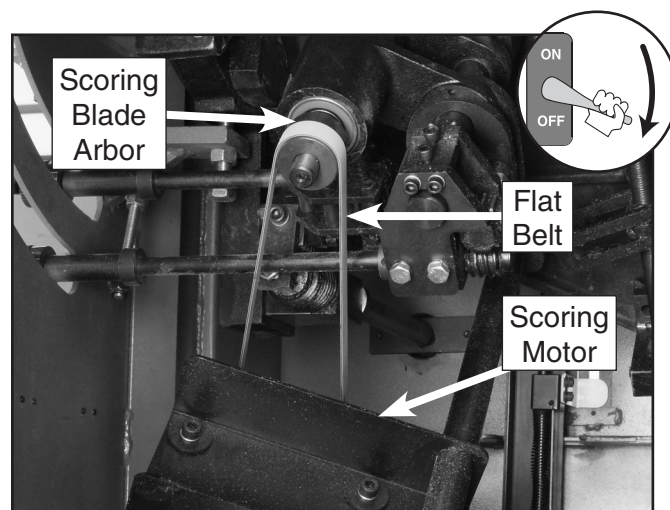


Figure 44. Flat belt installation.

- Move the blade tilt to 0° and raise the main blade as far as it will go.

- Slide the table all the way forward to access the blade arbor and pull open the blade guard (see **Figure 45**).

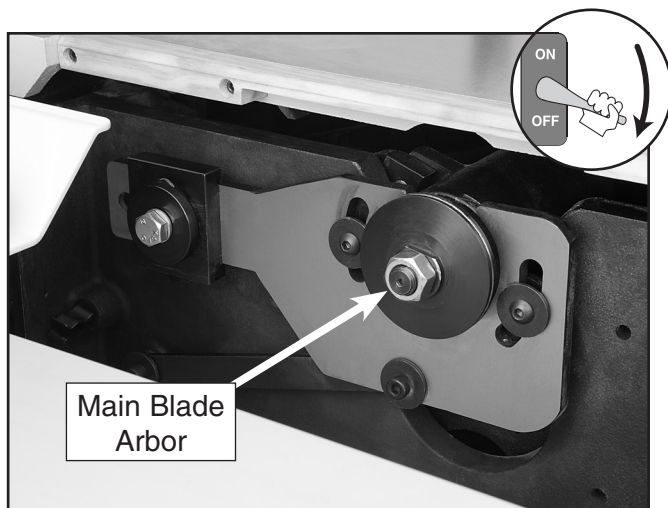


Figure 45. Main blade arbor components.

- Use the arbor wrench to remove the arbor nut and arbor flange. Note—*The arbor nut has left hand threads and loosens by turning clockwise.*
- Slide the blade over the arbor with the teeth facing the front of the saw as shown in **Figure 46**.



Figure 46. Installing the main blade.

- Re-install the arbor flange and the arbor nut and tighten them against the blade as shown in **Figure 46**.

Note—*Wear gloves to protect your hands when installing or removing blades.*

- Loosen the riving knife center bolt, slide the riving knife over the bolt as shown in **Figure 47**, and slightly tighten.



Figure 47. Installing the riving knife.

- Position the riving knife about 3mm or $\frac{1}{8}$ " away from the nearest carbide tooth on the main blade. Note—*For a quick gauge, use the 3mm hex wrench to find the correct spacing between the blade and the riving knife, as shown in **Figure 48**.*

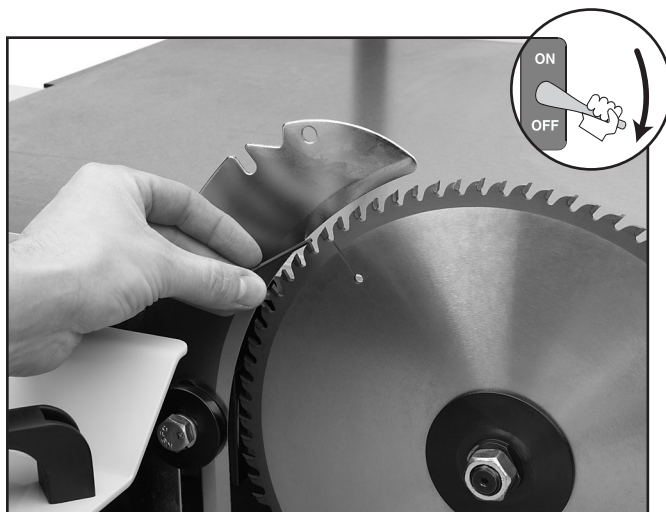


Figure 48. Adjusting the riving knife.

- Tighten the center bolt to secure the riving knife in position.
- Move the blade guard back to its original position, and move the sliding table back to center.



Aligning Scoring Blade Set

To align the scoring blade set:

1. Move the blade tilt to 0° (blade 90° to table), raise the main blade all the way up, and use the vertical adjustment knob (**Figure 49**) to raise the scoring blade to its highest point.

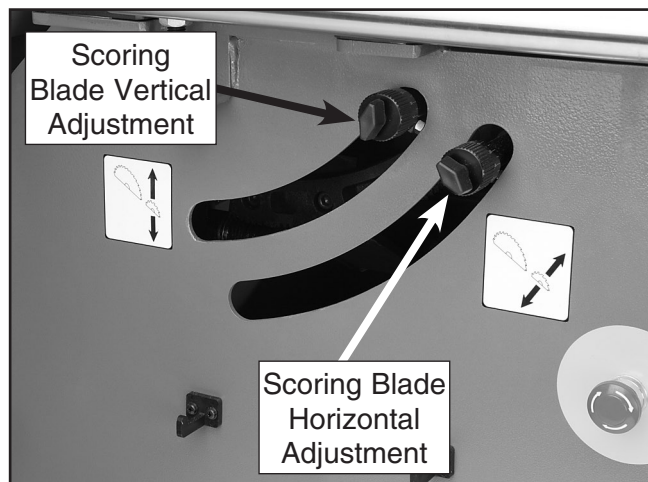


Figure 49. Scoring blade adjustment controls.

2. Move the rip fence against the main blade (or scoring blade) as shown in **Figure 50**.

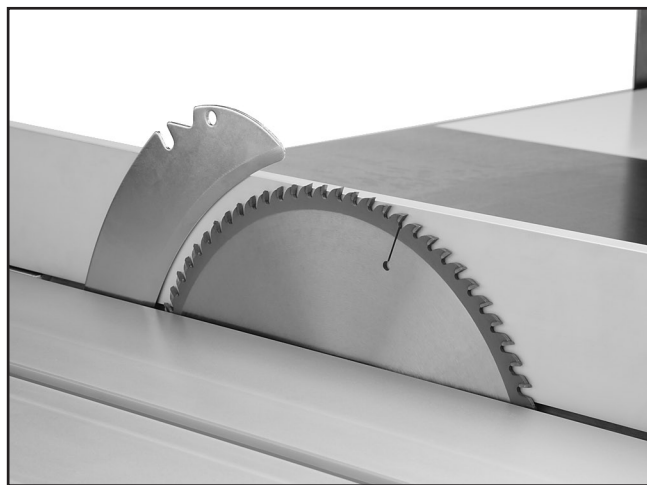


Figure 50. Fence used to align blades.

3. Use the horizontal adjustment controls to adjust the scoring blade until the rip fence can touch both blades.



Adjusting Scoring Blade Kerf

The kerf of the tapered scoring blade included with this sliding table saw is adjusted by changing the height of the scoring blade. See **Page 37** for replacement scoring blade adjusting instructions.

To change the scoring blade kerf:

1. Measure the main blade kerf, then measure the scoring blade kerf at the table level.
2. Raise or lower the scoring blade until the kerf matches the kerf of the main blade.
3. Perform a test cut and check for chip out on the underside of the test piece. If there is chip out, make the adjustments necessary to match the kerfs.



Scale Alignment

Before operation, align the rip fence scale with the blade to ensure accurate measurements.

Tools Needed:	QTY
Hex Wrench 3mm.....	1
Hex Wrench 8mm.....	1

To align the fence scale with the blade:

1. Tilt the blade to 0°, raise the main blade all the way up, and move the rip fence against the blade as shown in **Figure 50**.
2. Loosen the screws securing the scale, line up the first mark on the scale with the left edge of the rip fence, then tighten the screws.
3. Set the rip fence to 1/8", slide the adjustable ring against the fence, and secure the ring to prevent the fence from contacting the blade.



Dust Collection

The Model G0451 is equipped with two dust ports that should be properly connected to a dust collection system before operation.

Components and Hardware Needed:	Qty
Blade Guard/Dust Hood	1
Flat Washer 8mm	1
Button Head Screw M8-1.25 x 40	1
Dust Collection System	1
5" Dust Hose (length as needed)	1
5" Hose Clamp	2
2½" Dust Hose (length as needed)	1
2½" Hose Clamp	2

Tools Needed:

Hex Wrench 6mm	1
Phillips Head Screwdriver	1

To connect the dust ports to a dust collection system:

1. Secure a 5" dust hose to the dust port located under the saw table (**Figure 51**).

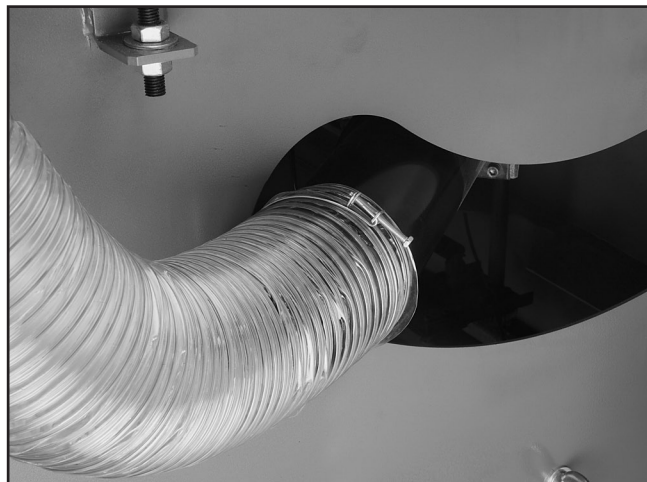


Figure 51. 5" dust port location.

2. Run the 5" hose to your dust collection system.

3. Slide the blade guard/dust hood over the riveting knife and attach it with an M8-1.25 x 40 button head cap screw and a flat washer as shown in **Figure 52**.

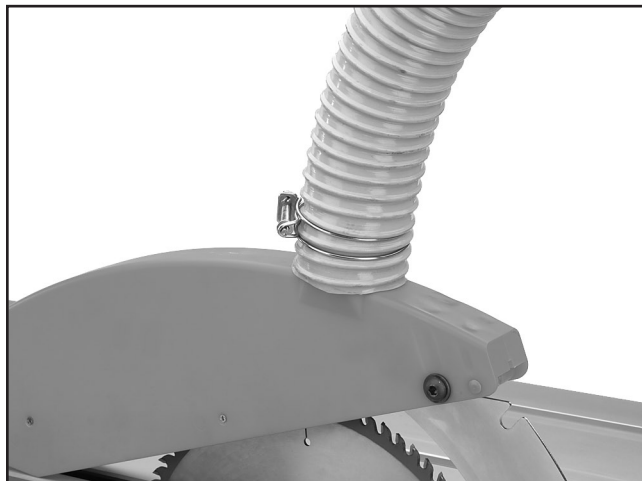


Figure 52. 2" dust port location.

4. Secure a 2½" dust hose to the dust port on the top of the blade guard as shown in **Figure 52**.
5. Run the 2½" hose over the hose support (**Figure 53**) and connect it to the dust collection system.

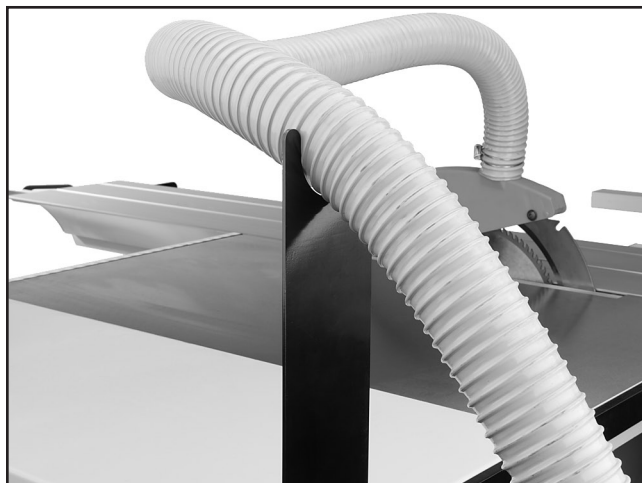


Figure 53. Dust hose support in use.

6. Run a ground wire through the dust hose and attach the wire to the machine to protect against static electricity.



Power Cord

Before installing the power cord, read through *Section 2: Circuit Requirements* to check that your setup follows the safety and circuit requirements, and the power cord and plug that you have chosen meet the requirements for this machine.

Components and Hardware Needed: Qty
Power Cord 1

Tools Needed:
Phillips Head Screwdriver 1

To connect the saw to the power source:

1. Open the terminal box shown in **Figure 54**.

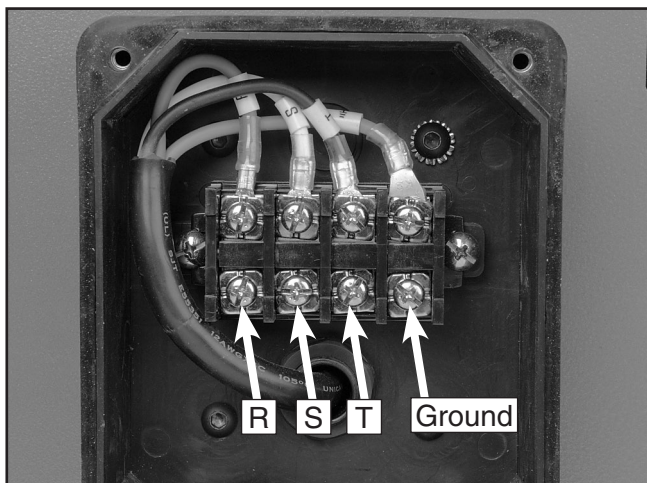


Figure 54. Main terminal box.

2. Feed the power cord through the strain relief on the bottom of the control panel and connect the cord to the terminals shown in **Figure 54**, then close the terminal box.

Note—When using a phase converter, connect the manufactured power leg to the S terminal. The S terminal can handle power fluctuation because it is wired directly to the motor. The other wires connect to the transformer and must be consistent to prevent damage.

3. **Shut off the main power at the power source circuit breaker** and install the cord to the disconnect switch.



Test Run

Now that the machine is connected to the power source, it is important to perform a test run to make sure all the controls are working properly.

WARNING

Before starting the saw, make sure you have performed the preceding assembly and adjustment instructions, and you have read through the rest of the manual and are familiar with the various functions and safety issues associated with this machine. Failure to follow this warning could result in serious personal injury or even death!

To test run the saw:

1. Put on safety glasses and make sure any bystanders are out of the way and also wearing safety glasses.
2. Insert the key into the control panel and turn it clockwise.
3. Rotate both of the red EMERGENCY STOP buttons until they spring up.
4. Press the main blade button then press the scoring blade button.

—If any problems occur, press the EMERGENCY STOP button.

—If the main blade is rotating in a counter-clockwise direction, disconnect the saw from power and exchange wires R & T in the terminal box.

—Investigate and correct the problem before operating the machine further. If you need help, refer to the *Troubleshooting* section in the back of this manual or contact our Service Department at (570) 546-9663.

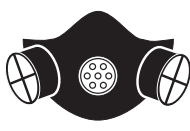


SECTION 4: OPERATIONS

Operation Safety

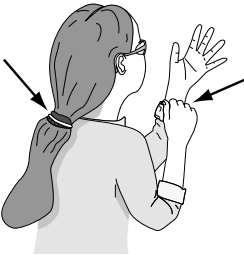
WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.



WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.



NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.



Operation Tips

Your safety is important. The tips below are intended to supplement *Section 1: Safety*. But remember, no safety list can be comprehensive of every situation. The operator is ultimately responsible for their own safety, as well as the safety of bystanders. Every cutting operation is uniquely different and may require safety equipment or safety procedures not mentioned in this manual.

Please follow these tips EVERY time you use your saw:

- Stand to the left of the blade line-of-cut when performing a cutting operation.
- Turn **OFF** the saw and allow the blade to come to a complete stop before removing the cut-off piece.
- Make sure that the riving knife is always aligned with the main blade before cutting!
- Always position the blade guard to the correct height above the workpiece.
- Carefully plan each cutting operation to avoid injuries.
- When you release the sliding table lock, make sure that the knob is positioned so that it will not lock the table during a cut.



Changing Main Blade

The Model G0451 will perform best when high quality, sharp blades are used. Therefore, whenever the main blade starts to get dull, we recommend that you have it resharpened or replace it with a new blade.

Also, the Model G0451 is designed to accommodate either a 12" or a 14" main blade. Any time you change blade size, adjust the riving knife to 3mm away from the blade you install.

To change the main blade:

1. **Disconnect the saw from the power source!**
2. Move the blade tilt to 0° (blade 90° to table) and raise the main blade as far as it will go.
3. Move the sliding table all the way forward to expose the internal blade guard that covers the blades and riving knife, as shown in **Figure 55**.

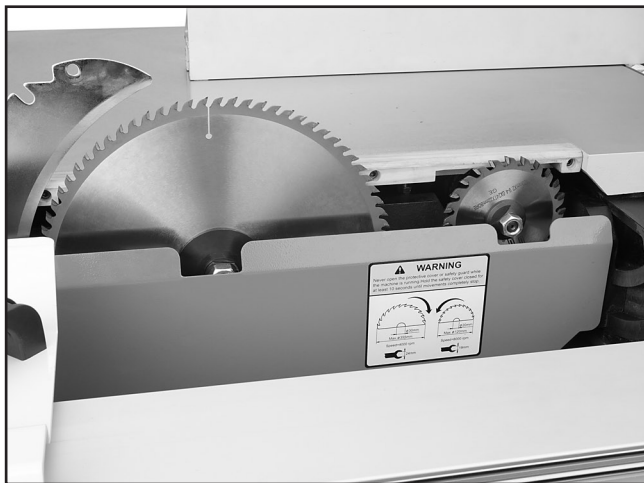


Figure 55. Internal blade guard exposed.

4. Pull the blade guard away from the blades to expose the mounting assembly. (The internal blade guard is held in place with a magnet.)

5. Use the arbor wrench to remove the arbor nut and arbor flange and pull the old blade off the arbor.

Note—The arbor nut has left hand threads and loosens by turning clockwise.

6. Slide the new blade over the arbor with the teeth facing the front of the saw as shown in **Figure 56**.

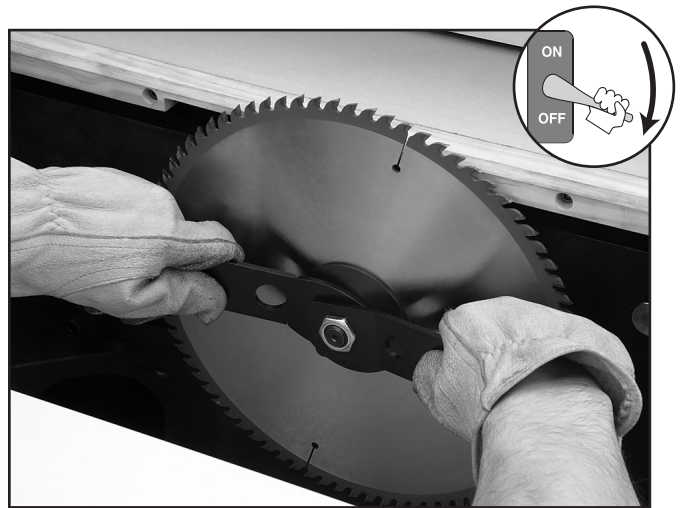


Figure 56. Replacing the main blade.

7. Re-install the arbor flange and the arbor nut and tighten them against the blade as shown in **Figure 56**.

Note—Wear gloves to protect your hands when installing or removing blades.

— If you changed the diameter of the blade during this procedure, adjust the riving knife according to the instructions titled *Riving Knife Adjustment* on **Page 36**.

8. Move the orange blade guard back into its original position, next to the blades, and center the sliding table.



Riving Knife Adjustment

Whenever the blade size is changed (12" or 14" blade), the riving knife must be adjusted to 3mm away from the blade you install.

To adjust the riving knife:

1. **Disconnect the saw from the power source!**
2. Move the blade tilt to 0° (blade 90° to table), and raise the main blade as far as it will go.
3. Move the sliding table all the way forward to expose the internal blade guard that covers the blades and riving knife.
4. Pull the blade guard away from the riving knife to expose the mounting assembly. (The internal blade guard is held in place with a magnet.)
5. Loosen the riving knife center bolt, slide the riving knife away from the blade as shown in **Figure 57**, and slightly tighten.

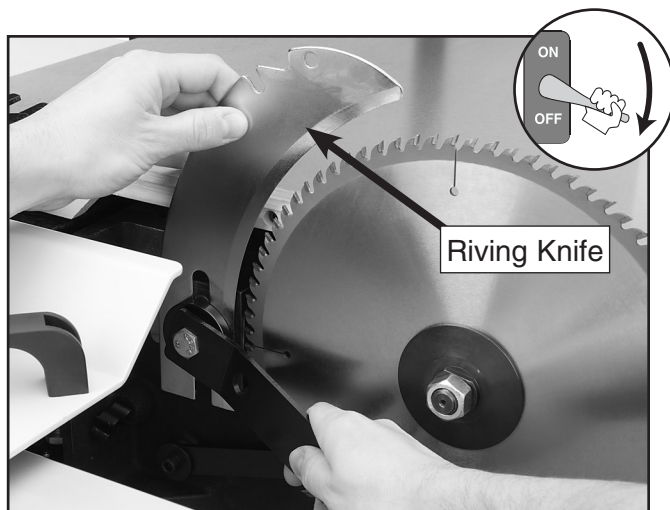


Figure 57. Re-adjusting the riving knife.

6. Position the riving knife about 3mm or 1/8" away from the nearest carbide tooth on the main blade. Note—*For a quick gauge, use the 3mm hex wrench to find the correct spacing between the blade and the riving knife, as shown in **Figure 58**.*

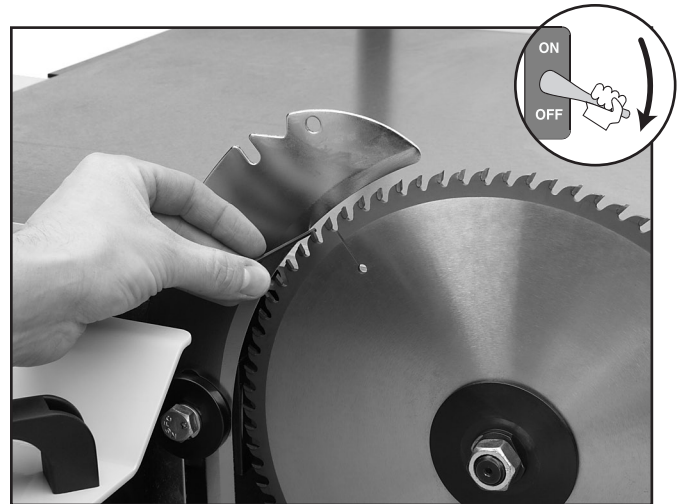


Figure 58. Aligning the riving knife.

7. Tighten the center bolt to secure the riving knife in position.
8. Move the blade guard back to its original position, and move the sliding table back to center.



Adjusting and Replacing Scoring Blade

The scoring blade that is included with the sliding table saw is wedge shaped. The kerf thickness of this style of scoring blade is adjusted by changing the height of the scoring blade. Most replacement scoring blade sets consists of an inner and outer blade with internal shims. The shims are provided so the scoring blade set can match the kerf thickness of the main blade. **Figure 59** shows a replacement scoring blade set laid out for identification. For optimum performance, replace the scoring blades when they start to get dull.

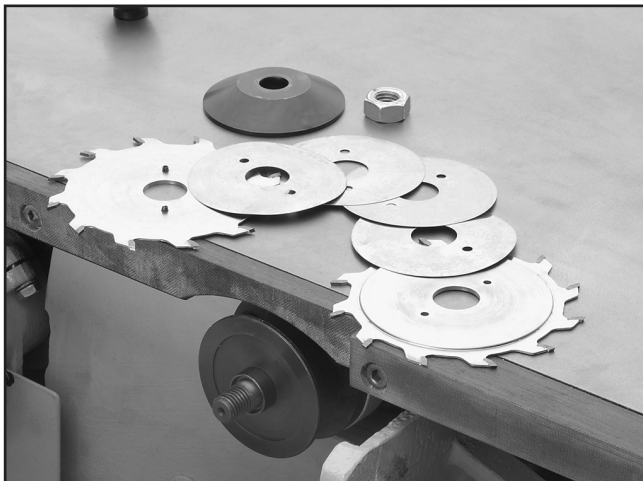


Figure 59. Scoring blade set.

To change the scoring blade:

- 1. Disconnect the saw from the power source!**
2. Move the blade tilt to 0° (blade 90° to table), and raise the scoring blade all the way up.
3. Move the sliding table all the way forward to expose the internal blade guard that covers the blades and riving knife.
4. To remove the scoring blade, use the arbor wrench to remove the arbor nut and arbor flange (see **Figure 60**). Note—*The arbor nut has right-hand threads and loosens by turning counterclockwise.*
5. Adjust the width of the scoring blade.
 - If you are using a tapered scoring blade, complete **Step 6**, then adjust the kerf as instructed on **Page 31** before continuing to **Step 7**.
 - If you are using a stacked scoring blade set, measure the main blade and use the shims to stack the set so the thickness matches the thickness of the main blade.
6. Install the new scoring blade, re-install the arbor flange and the arbor nut, and tighten them against the blade set.
7. Move the orange blade guard back into its original position, next to the blades, and center the sliding table.
8. Align the scoring blade set to the main blade as described in the “Aligning Scoring Blade Set” instructions on **Page 31**.
9. Perform a test cut and check for chip out on the underside of the test piece. If there is chip out, make the adjustments necessary to match the kerfs.

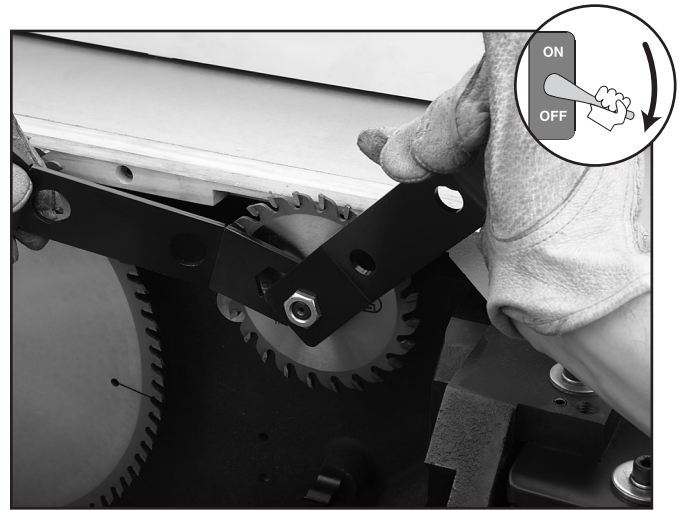


Figure 60. Removing the scoring blade.



Rip Cutting

The Model G0451 has the capability of rip cutting full size panels (**Figure 61**). The sliding table removes the burden of sliding a large and heavy panel over a stationary table surface.

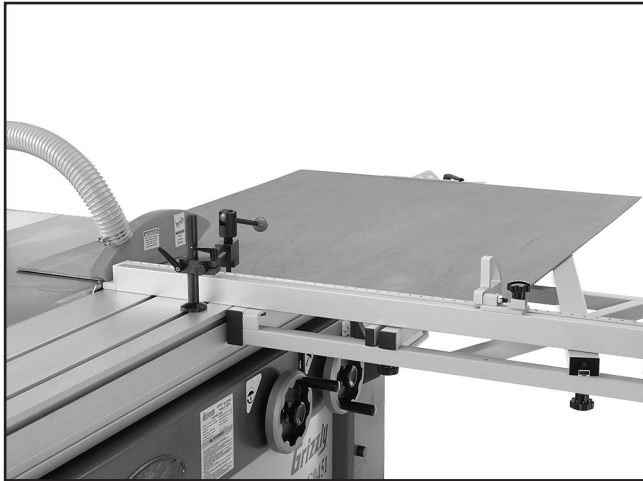


Figure 61. Rip cutting with the sliding table.

This saw also has the capability of rip cutting smaller boards, using the machine as a traditional table saw (**Figure 62**). Smaller, lighter boards are easier to slide across the stationary cast iron table surface to the right of the saw blade.



Figure 62. Traditional rip cutting.

Determine which cutting operation will be best suited for the workpiece to be ripped.

—To use the sliding table, read the instructions titled “Rip cutting with the sliding table.”

—To use the machine as a traditional table saw, skip ahead to “Rip cutting using the traditional table saw technique.”

Rip cutting with the sliding table:

1. Drop the crosscut fence into the center stud hole and rotate it until the spring pin shown in **Figure 63** snaps into the T-slot.
2. Check to make sure the fence is at 90° and adjust it as described in “Squaring Crosscut Fence to Blade” on **Page 52** if necessary.

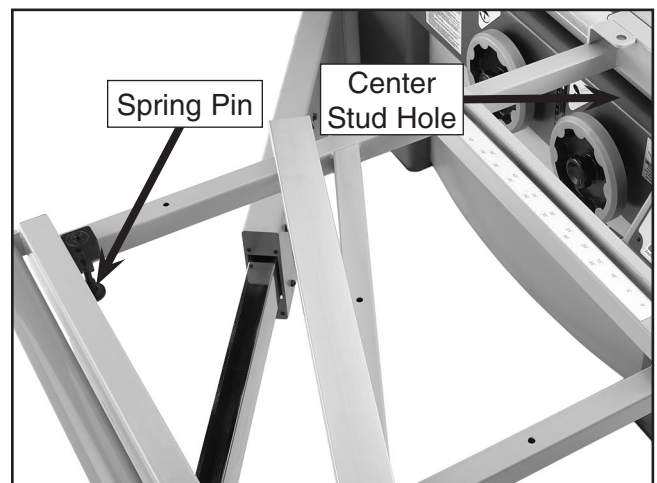


Figure 63. Crosscut fence mounting locations.

3. Slide the protection block against the blade teeth to calibrate the scale, then tighten the lock knob. Note—*The scale will not be accurate if the protection block is cut.*
4. Set a flip stop to the desired width-of-cut.
5. Position the blade guard to the correct height for your workpiece.
6. Load the workpiece onto the table saw. The set up should look similar to **Figure 61**.
7. Take all the necessary safety precautions, then perform the cutting operation.

Rip cutting using the traditional table saw technique:

1. Slide the crosscut table out of the way.
2. Lock the sliding table into a stationary position (see **Figure 64**).

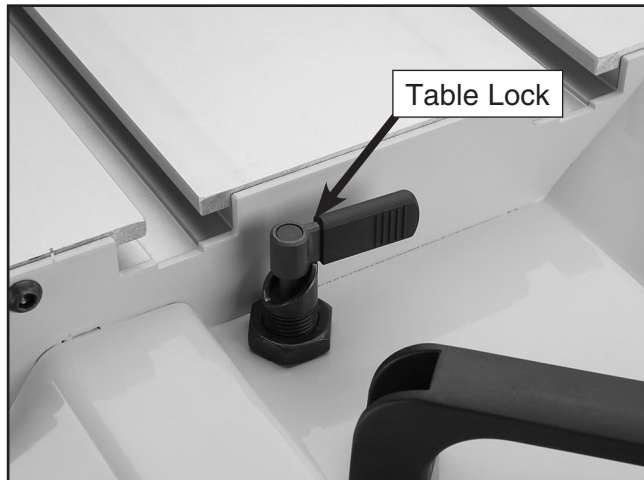


Figure 64. Sliding table lock.

3. Place the fence in the vertical position for larger workpieces, or in the horizontal position for angled cuts and for small workpieces (see **Figure 65**).

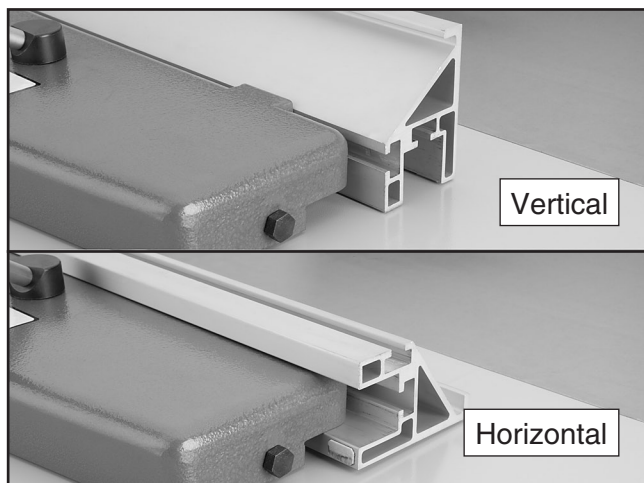


Figure 65. Rip fence positions.

4. Slide the leading end of the rip fence so it is even with the center of the main saw blade as shown in **Figure 66**. Note—*This technique allows the finished cut-off piece to “fall” away from the blade when the cutting operation is complete; reducing the possibility of kick-back.*

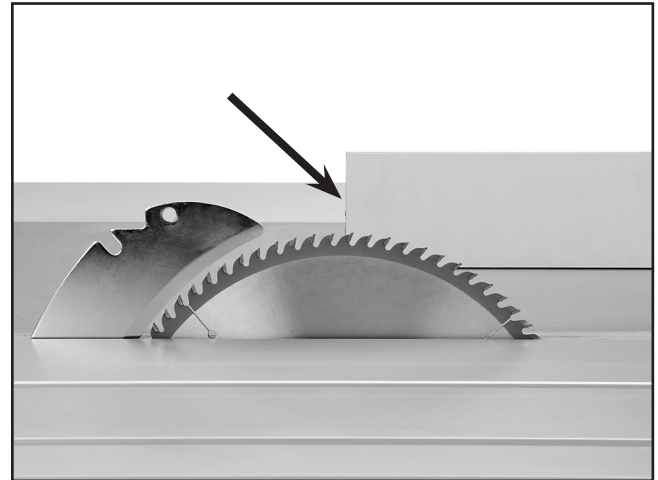


Figure 66. Rip fence even with center of blade (Blade guard removed for clarity).

5. Lift the lock lever and position the rip fence to approximately the desired width-of-cut.
6. Tighten down the micro-adjust lock knob (**Figure 67**) and turn the micro-adjust knob to zero in on the desired width-of-cut.

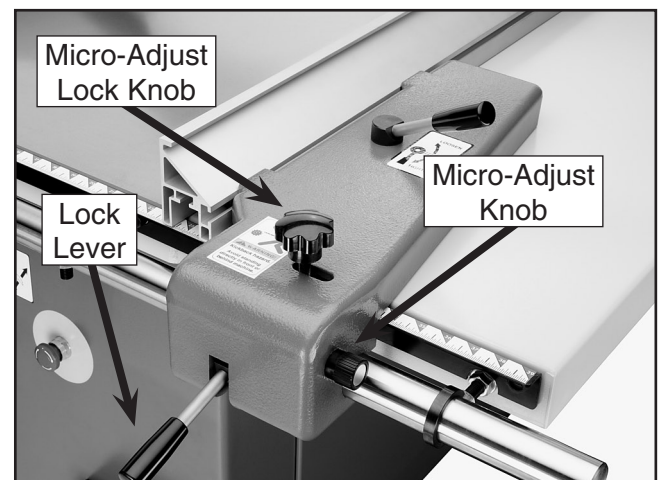


Figure 67. Rip fence micro-adjusting controls.

7. Push down the lock lever, then perform the cutting operation.



Crosscutting

The Model G0451 can crosscut full size panels with the fence in the forward or rear position, although it is easier to load full size panels with the crosscut fence mounted in the forward position (see **Figure 68**).

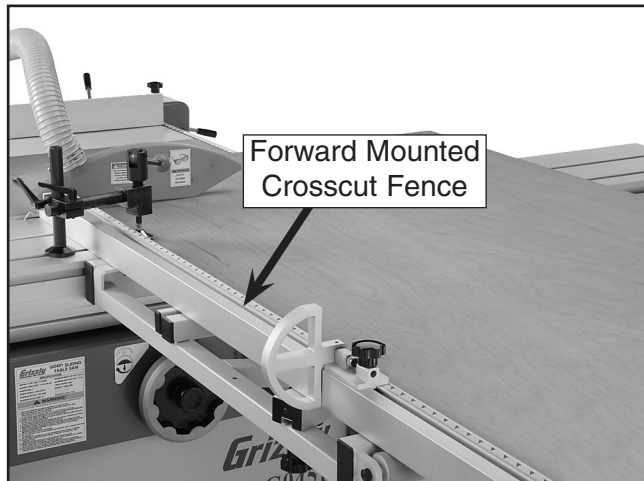


Figure 68. Crosscutting full size panel.

Mounting the crosscut fence in the rear position (**Figure 69**) gives greater stability for crosscutting smaller panels.

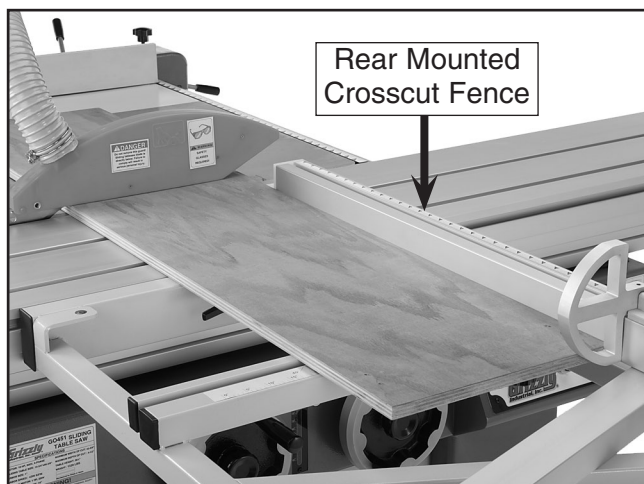


Figure 69. Crosscutting smaller panels.

Lastly, this machine has the capability of crosscutting workpieces while using the rip fence as a cut-off gauge (**Figure 70**).

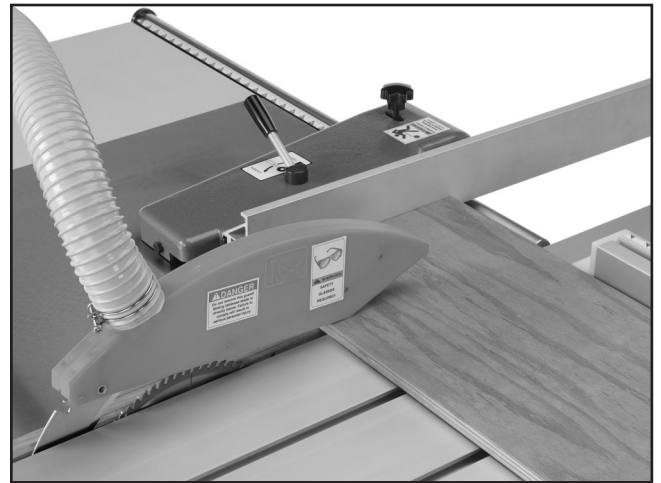


Figure 70. Crosscutting workpieces using the rip fence as a cut-off gauge.

Determine which cutting operation will be best suited for the workpiece to be crosscut.

- If you will be crosscutting full size panels, then skip ahead to “Crosscutting full size panels.”
- If you will be crosscutting smaller panels, then skip ahead to “Crosscutting smaller panels.”
- If you will be crosscutting workpieces using the rip fence as a cut-off gauge, then skip ahead to “Crosscutting using the rip fence as a cut-off gauge.”

Crosscutting full size panels:

1. Install the crosscut fence in the forward mounting points shown in **Figure 71** and lock it in place.
2. Check to make sure the fence is at 90° and adjust it as described in "Squaring Crosscut Fence to Blade" on **Page 52** if necessary.

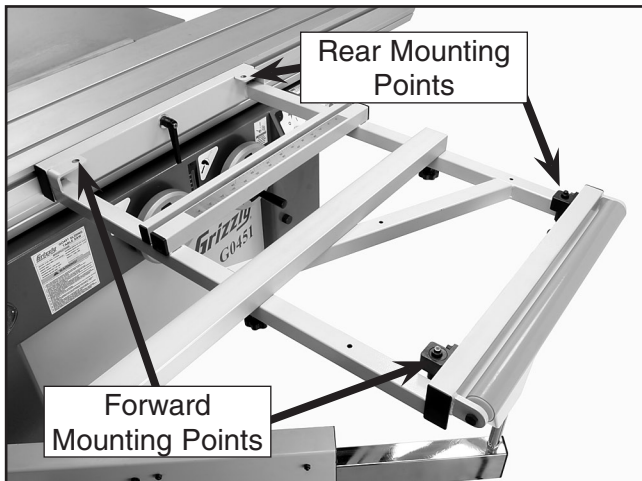


Figure 71. Crosscut fence mounting points.

3. Set either flip stop to the desired width-of-cut. Note—*Extend the crosscut fence slide if the workpiece is more than 74"*.
4. Load the workpiece onto the table saw. The set up should look similar to **Figure 68**.
5. Once all the necessary safety precautions have been taken, perform the cutting operation.

Crosscutting smaller panels:

1. Install the crosscut fence in the rear mounting points shown in **Figure 71** and lock it in place.
2. Check to make sure the fence is at 90° and adjust it as described in "Squaring Crosscut Fence to Blade" on **Page 52** if necessary.
3. Set either flip stop to the desired width-of-cut. Note—*Extend the crosscut fence slide if the workpiece is more than 74"*.

4. Load the workpiece onto the table saw. The set up should look similar to **Figure 69**.
5. Once all the necessary safety precautions have been taken, perform the cutting operation.

Crosscutting using the rip fence as a cut-off gauge:

1. Install the crosscut fence in the rear mounting points shown in **Figure 71** and lock it in place.
2. Check to make sure the fence is at 90° and adjust it as described in "Squaring Crosscut Fence to Blade" on **Page 52** if necessary.
3. Position the rip fence for the desired width.
4. Load the workpiece onto the table saw. The set up should look similar to **Figure 70**.
5. Slide the leading end of the rip fence behind the back edge of the blade as shown in **Figure 72**.

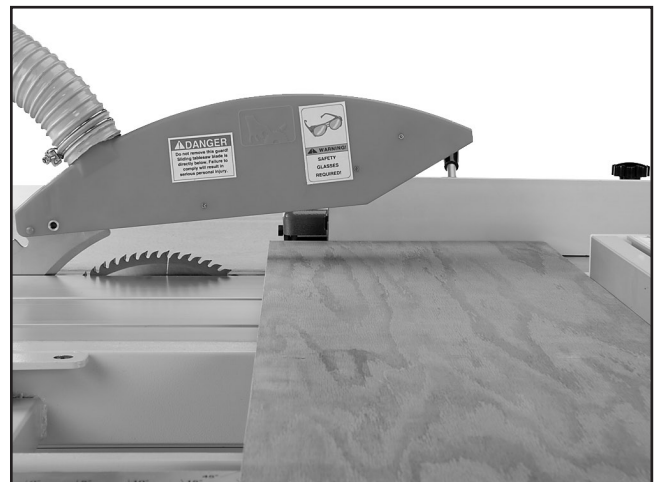


Figure 72. Correct rip fence position when using it as a cut-off gauge.

6. Take all the necessary safety precautions, then perform the cutting operation.



Miter Cutting

The miter fence allows miter cuts from 0° through 135°. The table mounted miter scale has a resolution of 1°.

To perform a miter cut:

1. Slide the crosscut table to the front edge of the sliding table and lock it in place.
2. Place the crosscut fence center stud in the center stud hole of the crosscut table. The fence can be installed as shown in **Figure 73** for 90° to 135° cuts, or as shown in **Figure 74** for 0° to 90° cuts.

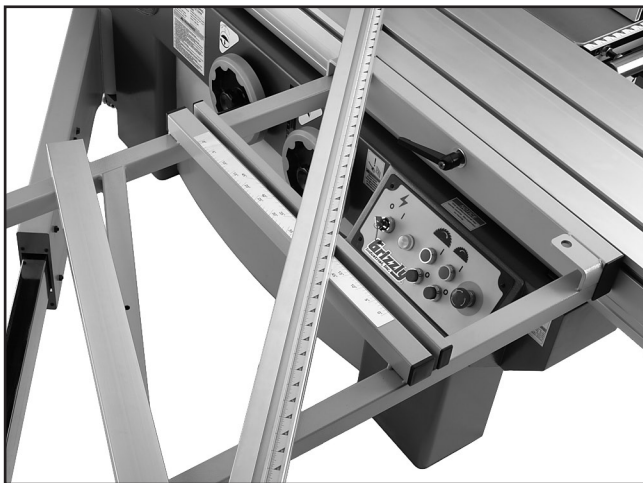


Figure 73. Fence set-up for 90° to 135° cuts.

3. Rotate the fence to the desired angle and use the lock knob to lock the fence in place.
4. Position the flip stop according to the length of the workpiece you want to cut off to the left of the blade.
5. Load the workpiece onto the table saw. The set up should look similar to **Figure 74**.

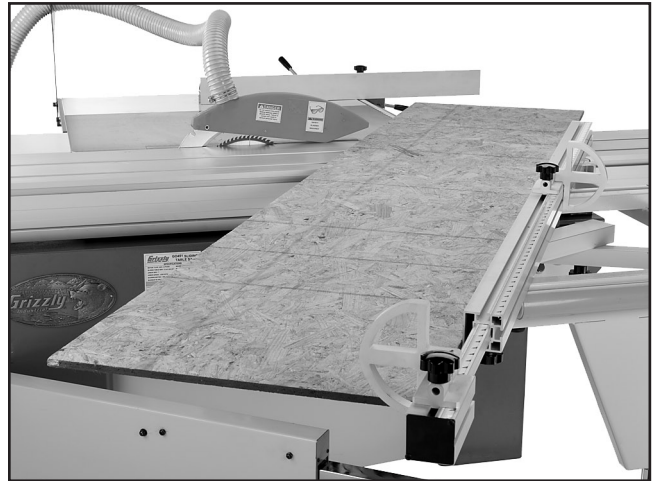


Figure 74. Example of miter cutting operation.

6. Once all the necessary safety precautions have been taken, perform the cutting operation.



SECTION 5: ACCESSORIES

G7895—Citrus Degreaser

This citrus based degreaser is perfect for cleaning cosmoline off of new equipment. It also works for cleaning auto parts, tools, concrete, and porcelain surfaces. Natural, safe for the environment, and contains no CFC's.



Figure 75. G7895 Citrus Degreaser.

G1955—OxiSolv® Blade & Bit Cleaner

Used to clean the gummy pitch and residue from saw blades and router bits, this high quality cleaner will make blades and bits last longer while improving cutting action.



Figure 76. G1955 OxiSolv®.

G5562—SLIPIT® 1 Qt. Gel

G5563—SLIPIT® 12 oz Spray

Used on cast iron table surfaces and other unpainted metal surfaces to reduce sliding friction and hangups. This product also reduces rust and prevents resin build-up.



Figure 77. G5562 & G5563 SLIPIT.

G2871—Boeshield® T-9 12 oz Spray

G2870—Boeshield® T-9 4 oz Spray

This ozone friendly protective spray penetrates deep and really holds up against corrosive environments. Lubricates metals for months and is safe for use on most paints, plastics, and vinyls.



Figure 78. Boeshield® T-9 spray.

Call 1-800-523-4777 To Order

- G7984—Face Shield**
- H1298—Dust Sealed Safety Glasses**
- H1300—UV Blocking, Clear Safety Glasses**
- H2347—Uvex® Spitfire Safety Glasses**
- H0736—Shop Fox® Safety Glasses**

Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!



Figure 79. Our most popular safety glasses.

- H2499—Small Half-Mask Respirator**
- H3631—Medium Half-Mask Respirator**
- H3632—Large Half-Mask Respirator**
- H3635—Disposable Cartridge Filter Pair P100**

Wood dust is now considered a known carcinogen and has been linked to nasal cancer and severe respiratory illnesses. If you work around dust everyday, a half-mask respirator can be a lifesaver. Also compatible with safety glasses!



Figure 80. Half-mask respirator and disposable cartridge filters.

- H3388—14" Carbide Tipped Saw Blade, 80T**
 - H3389—14" Carbide Tipped Saw Blade, 100T**
- These blades are designed especially for sliding table saws and manufactured for heavy-duty use.

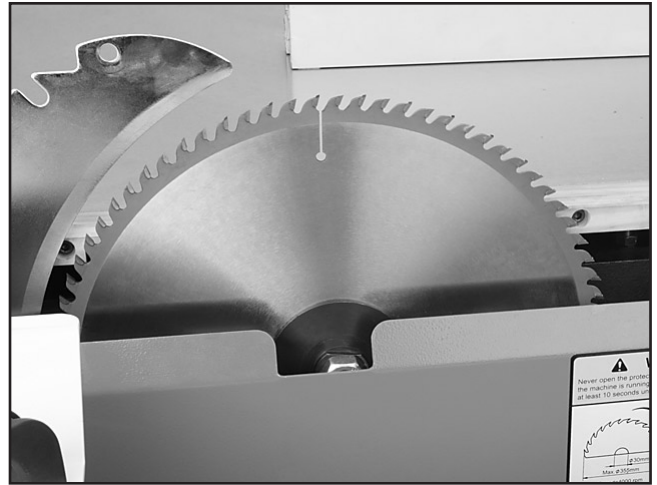


Figure 81. Carbide-tipped saw blade.

H4935—Scoring Blade Set

The scoring blade set consists of an inner and outer blade and four internal shims. Two shims are 0.008" thick and two are 0.004". The shims are provided so the scoring blade set can match the kerf thickness of the main blade.

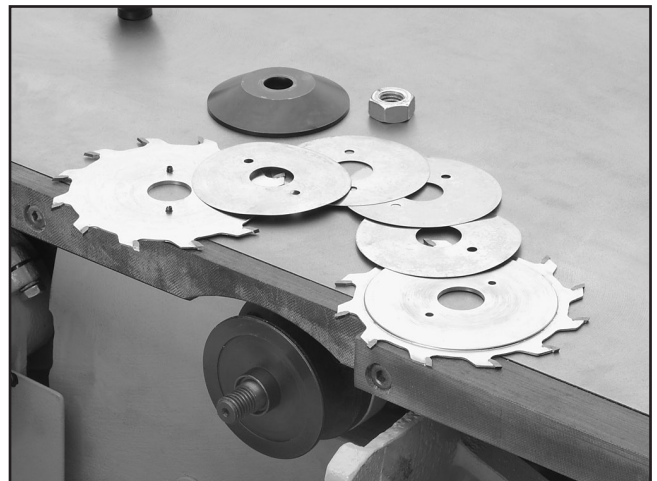


Figure 82. H4935 Scoring Blade Set.

H3308—SHOP FOX® Push Stick

Measuring 13½" overall, this push stick allows the operator to keep their hands at a safe distance away from the blade or cutter.

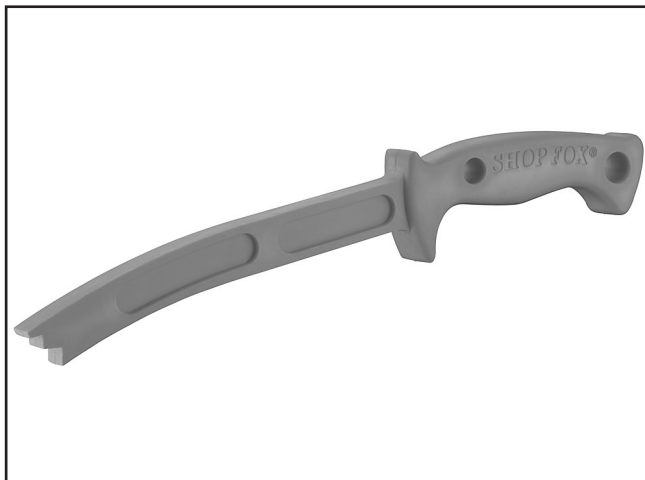


Figure 83. H3308 SHOP FOX® Push Stick.

G3445—Precision Saw Tool

This high impact plastic Saw Aid™ quickly measures blade height and angle and can also serve as a solid push stick. Includes a graduated ruler guide and center finder.

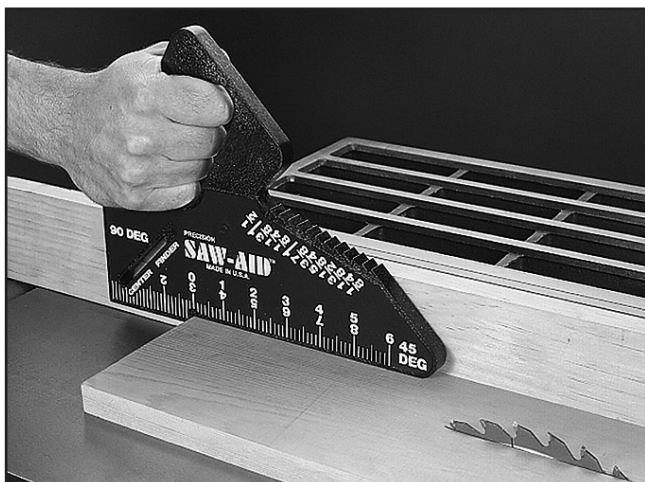


Figure 84. G3445 Precision Saw Tool.

H3771—Blade Loc®

This simple tool secures the blade during blade changes, keeping your hands safe and your expensive blade from being damaged.



Figure 85. H3771 Blade Loc®.

G7581—Superbar™

G7582—Master Plate

The miter slot mounted Superbar™ will align, tune and calibrate your tablesaw to within ±0.001 in just minutes. Replace your tablesaw blade when calibrating the double disk ground Master Plate for a precision measurement, with no runout!

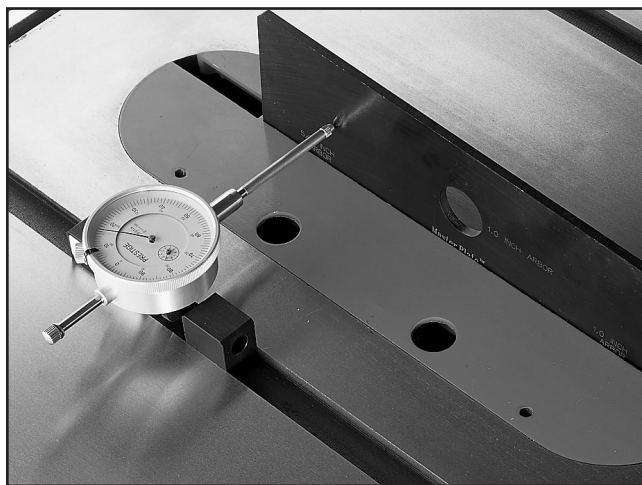
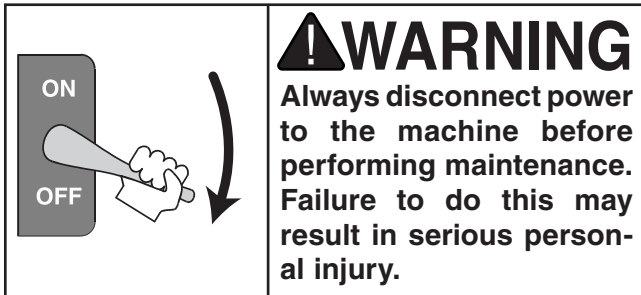


Figure 86. Superbar™ and Master Plate.

Call 1-800-523-4777 To Order



SECTION 6: MAINTENANCE



Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:

- Loose mounting bolts.
- Worn or damaged saw blade.
- Worn or damaged switches or wires.
- Any other unsafe condition.

Weekly Maintenance:

- Clean sliding table surface and grooves.
- Clean the cast iron saw table.
- Clean the sliding table roller guideways.
- Clean the rip fence and sliding grooves.
- Clean the rip fence bracket.

Monthly Check:

- Clean/vacuum dust buildup from inside cabinet and off motor.
- V-belt tension, damage, or wear.

Note—To ensure optimum power transmission from the motor to the blades, the V-belts must be in good condition (free from cracks, fraying and wear) and operate under proper tension.



Cleaning

Cleaning the Model G0451 is relatively easy. Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. Use compressed air to blow dust from between the two sections of the sliding table. If any resin has built up, use a resin dissolving cleaner to remove it. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.



Unpainted Cast Iron

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces.

Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9 (see *Section 5: Accessories* on **Page 43** for more details).



Lubrication

The bearings are sealed and pre-lubricated and require no lubrication during their usable life. However, your saw components will operate at their best if the bearing surfaces are kept clean—this is especially important for the trunnion bearings.

Lubricate the areas indicated below every 6-12 months, depending on frequency of use.

1. **Blade angling trunnions.** These should be lubricated with 6 or 7 drops of light machine oil (see **Figure 87**).

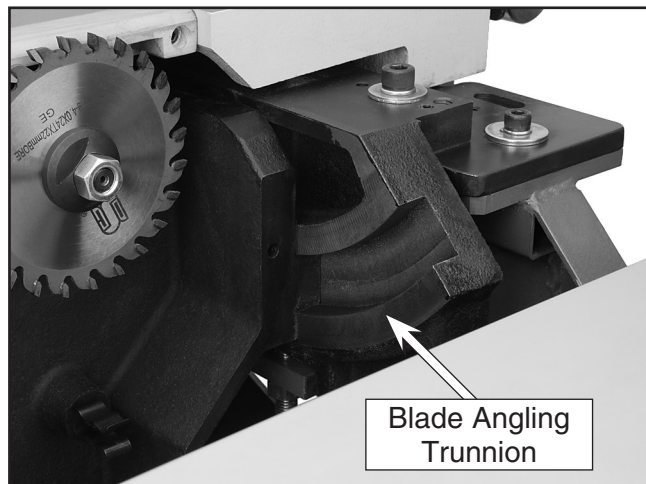


Figure 87. Blade angling trunnions.

2. **Sliding table ways.** Spray or wipe on a light machine oil such as WD-40® the entire length of the steel rods (see **Figure 88**).

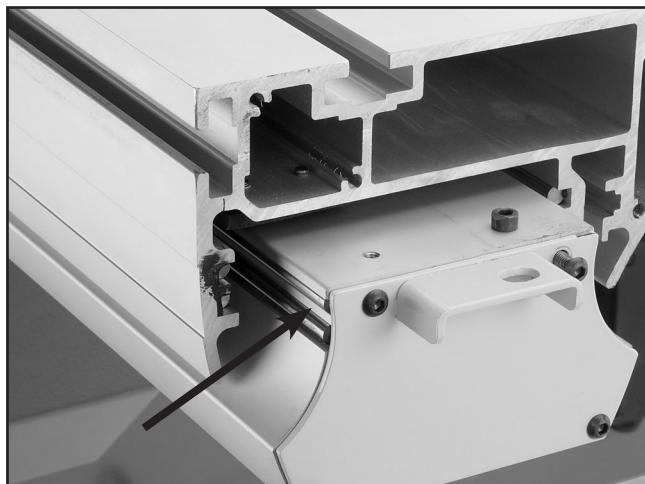


Figure 88. Sliding table ways.

3. **Scoring blade worm gears.** Lubricate with an automotive wheel bearing grease.

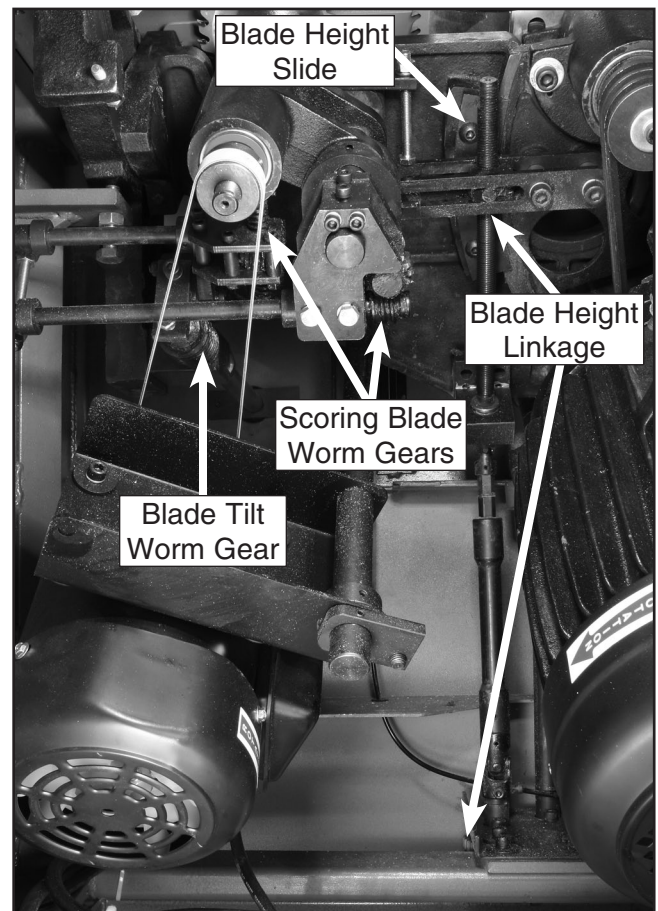


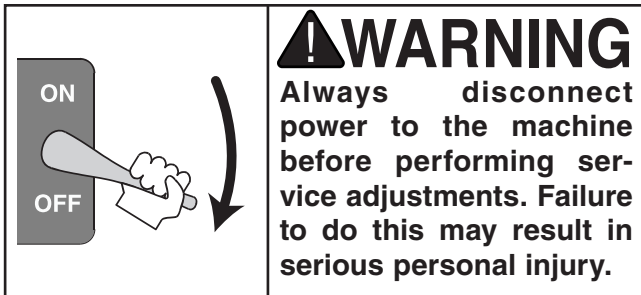
Figure 89. Gear lubrication.

4. **Blade height linkage.** Lubricate with an automotive wheel bearing grease.
5. **Blade height bearing** (Hidden behind the motor in **Figure 89**). Lubricate with an automotive wheel bearing grease in a grease gun.
6. **Blade tilt worm gear.** Lubricate with an automotive wheel bearing grease.
7. **Blade height slide.** Lubricate with an automotive wheel bearing grease.





SECTION 7: SERVICE



About Service

This section is designed to help the operator with adjustments that were made at the factory and that might also need to be made during the life of the machine.

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If any adjustments arise that are not described in this manual, then feel free to call the Grizzly Service Department at (570) 546-9663.

Similarly, if you are unsure of how to perform any procedure in this section, the Grizzly Service Department will be happy to guide you through the procedures or help in any other way.



Replacing Belts

To change the V-belt on the main motor:

1. Disconnect the saw from the power source!
2. Move the blade tilt to 0° (blade 90° to table), and raise the main blade and scoring blade set up as far as they will go.
3. Open the motor cabinet door.
4. Loosen the tension bolt (**Figure 90**) and pivot the motor up to remove the V-belts. Note—You may need to use a hydraulic bottle jack to lift the motor.

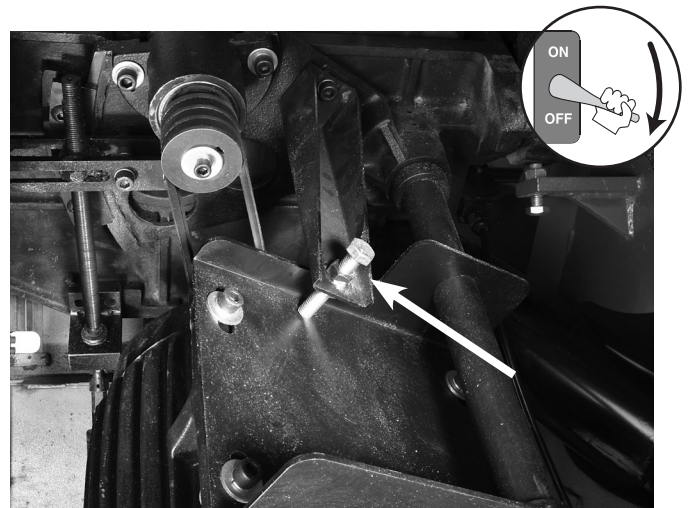


Figure 90. V-belt tension bolt.

5. Remove the old V-belts and replace them with new belts. Note—Always replace all of the belts as a matched set.
6. Tighten the tension bolt until the belts deflect between a ¼" and a ½" when pressed firmly in the center of each V-belt.
7. Close and secure the motor cabinet door.

To change the belt on the scoring blade motor:

1. **Disconnect the saw from the power source!**
2. Move the blade tilt to 0° (blade 90° to table), and raise the main blade and scoring blade set up as far as they will go.
3. Open the motor cabinet door.
4. Push the scoring blade motor and remove the flat belt.
5. Place the flat belt on the scoring blade arbor as shown in **Figure 91**, lift the scoring motor, and slide the flat belt over the scoring motor pulley.

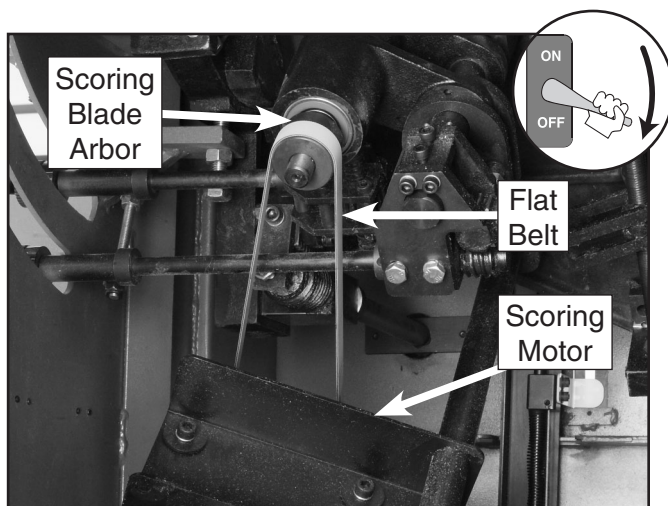


Figure 91. Replacing the scoring motor belt.

6. Close and secure the motor cabinet door.



Blade Tilt

The blade tilt is calibrated at the factory, but can be adjusted if it changes during the life of the machine.

To calibrate the blade tilt:

1. **Disconnect the saw from the power source!**

2. Move the blade tilt to 90° according to the gauge, and raise the main blade as far as it will go.
3. Place a machinist's square between the teeth on the blade and on the table surface and inspect for gaps between the blade and the square.
4. If a gap exists at either the top or bottom of the square, loosen the 90° tilt stop bolt shown in **Figure 92**.

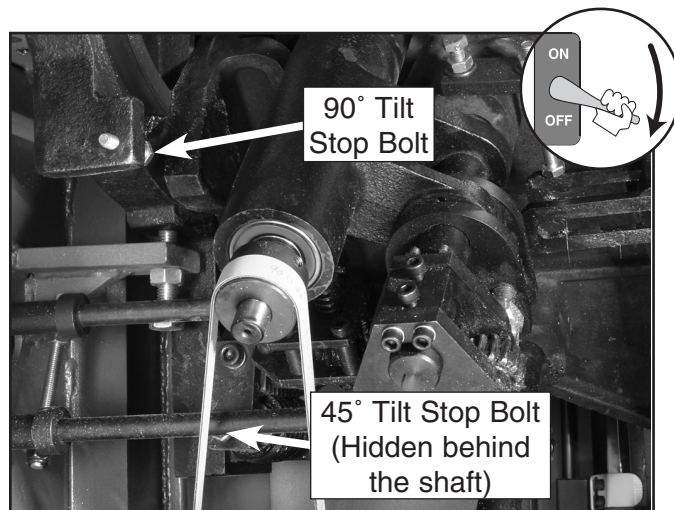


Figure 92. Blade tilt stop bolts.

5. Turn the handwheel until the blade and square are flush from top to bottom.
6. Snug the adjustment screw against the underside of the table and tighten the lock nut.
7. Recheck the blade with the square to ensure the screw has not been over-tightened.
8. Adjust the blade angle until you hit the 45° positive stop. Check the bevel with an adjustable square set to 45°.
9. If variations exist, adjust the 45° tilt stop bolt (**Figure 92**) until the blade and square match.
10. Tighten the lock nut and recheck the bevel by adjusting the blade back to 90°, then back to 45°.



Sliding Table Parallel Adjustment

The table is calibrated at the factory, but can be adjusted if it changes during the life of the machine.

Besides the tools included with the saw, this procedure requires you to have a felt tip pen, an adjustable square and a set of feeler gauges, or a dial indicator. Note—*Using a dial indicator will provide much more accurate results.*

To adjust the sliding table parallel with the main blade:

1. **Disconnect the saw from the power source!**
2. Move the blade tilt to 0° (blade 90° to table), and raise the main blade and scoring blade set up as far as they will go.
3. Make a mark near the edge of the blade with a felt tip pen. This will allow you to take your measurements from the exact same place on the blade.
4. Using an adjustable square or a dial indicator, measure the distance (A) between the miter slot and the front of the blade as shown in **Figure 93**.

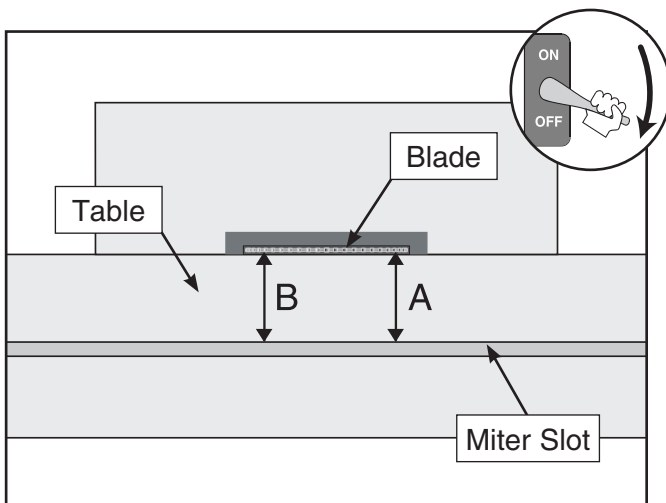


Figure 93. Measuring gap between the table and the blade.

5. Rotate the blade 180° and slide the table with the measuring device to position B.
6. Measure the difference between the two positions (use the feeler gauge if using the adjustable square). Make note of the difference between the two measurements on a piece of paper.
 - If the gap is the same on both sides, then the sliding table is already parallel with the main blade.
 - If the gap on one side is different than the other, then continue with **Step 7**.
7. Tilt the blade to 45° and repeat **Steps 4-6**.
 - If the difference was less than 0.004" when the blade was positioned at 90° and 45°, then the blade parallelism is correct.
 - If the difference was greater than 0.004" when the blade was positioned at 90° or 45°, then the trunnion assembly below the table needs to be adjusted. Continue with the next step.
8. Open the cover plates under each end of the table as shown in **Figure 94**, and loosen the table mounting bolts.

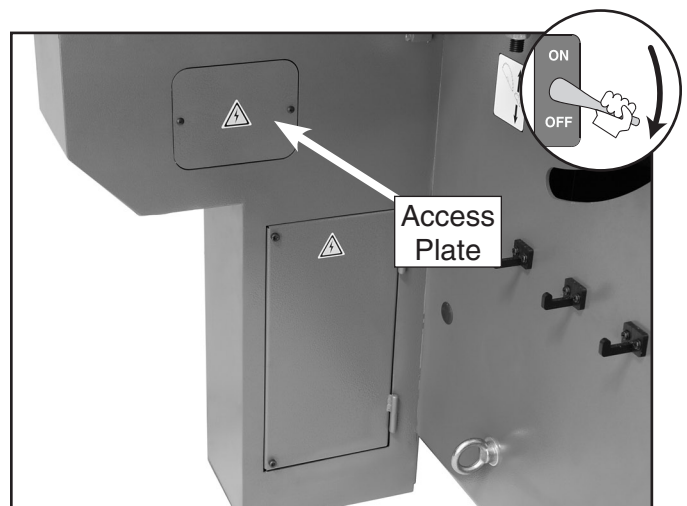


Figure 94. Table mounting bolt access plate.

9. Slowly make the adjustments to the parallelism adjustment bolts (**Figure 95**) on the end that is closer to the blade.

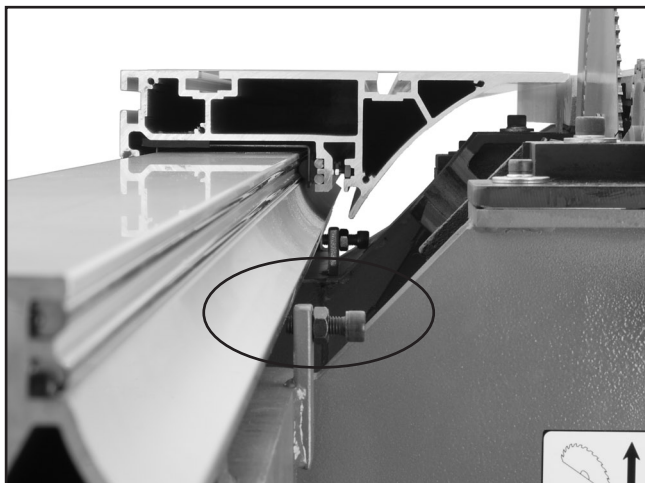


Figure 95. Table parallelism adjustment bolts.

10. Repeat **Steps 4-9** until the gap between the blade and the sliding table is equal.
11. Tighten the jam nuts on the parallel adjustment bolts to secure them in place
12. Tighten the table mounting bolts and replace the access plates.



Squaring Crosscut Fence to Blade

Squaring the crosscut fence to the blade ensures that cuts made with the crosscut fence will be square. This procedure can be done by using a piece of scrap plywood as a test piece and making five test cuts, then adjusting the fence as necessary.

To square the crosscut fence with the blade:

1. Make sure the blade is parallel with the sliding table.
2. Prepare the scrap test piece by cutting it to 32" x 32" and number all four sides of the test piece.

3. Use the crosscut fence to cut $\frac{1}{2}$ " off of each side of the test piece, then cut side 1 again (make five cuts total).
4. Measure the test piece diagonally from corner-to-corner as shown in **Figure 96**.
 - If both measurements are not within $\frac{1}{16}$ ", then the crosscut fence needs to be adjusted. Proceed to **Step 6**.
 - If both measurements are within $\frac{1}{16}$ " then you are finished with this procedure.

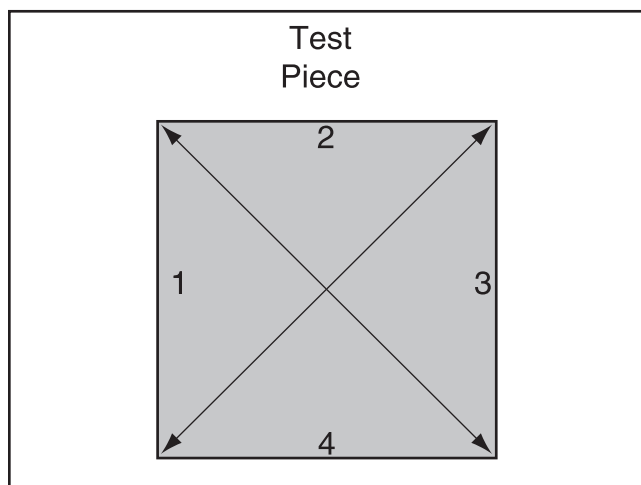


Figure 96. Fence adjustment test piece.

5. Loosen the set screw shown in **Figure 97** and rotate the cam to square the crosscut fence.

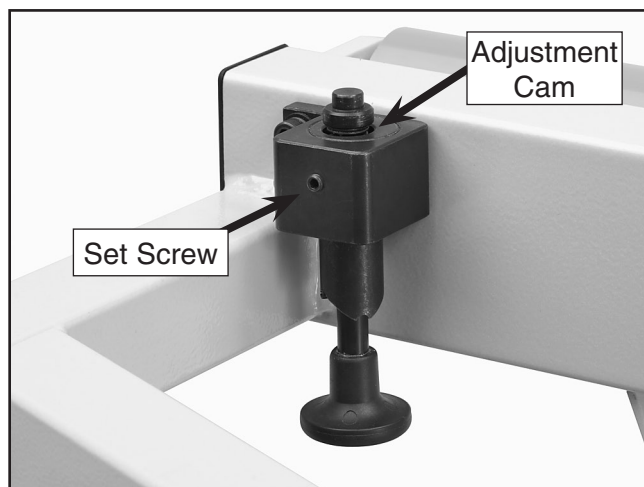


Figure 97. Crosscut fence adjustment cam.

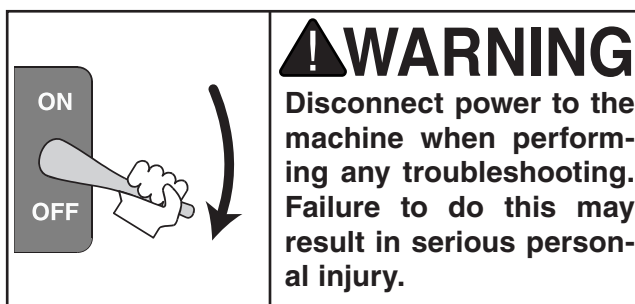
6. Tighten the set screw and repeat **Step 3-6**.





Troubleshooting

Symptom	Possible Cause	Possible Solution
Motor will not start, or it growls on start up.	1. Emergency stop button is depressed. 2. Power supply fuse or circuit breaker has tripped. 3. Thermal overload has tripped. 4. Toggle switch is broken inside. 5. Start capacitor is at fault. 6. Motor fan cover is dented, stopping the fan from being able to spin. 7. Motor is at fault.	1. Rotate the button clockwise and allow it to pop out. 2. Disconnect power, and inspect circuit for electrical shorts and repair. Replace circuit breaker if it is old or has tripped many times. 3. Reset the thermal overload. 4. Disconnect power, and use an ohmmeter to check switch terminals for continuity, and replace switch if required. 5. Replace start capacitor. 6. Replace motor fan cover (and fan, if damaged). 7. Replace motor.
Motor fails to develop full power (output of motor decreases rapidly with decrease in voltage at motor terminals).	1. Power line overloaded with lights, appliances, and other motors. 2. Undersized wires or circuits too long. 3. Blown capacitor.	1. Reduce load on power line. 2. Increase wire sizes or reduce length of the circuit. 3. Replace the capacitor.
Motor overheats.	1. Motor overloaded. 2. Air circulation through the motor restricted.	1. Reduce load on motor. 2. Clean out motor to provide normal air circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded.	1. Repair loose or shorted terminals, or worn insulation on motor. 2. Correct the low voltage conditions. 3. Install correct fuses or circuit breakers. 4. Reduce load on motor.
Main blade runs backwards.	1. Two of the power wires are reversed.	1. Exchange wires R & T in the terminal box.
Blade slows when cutting. Blade makes a squealing noise on start-up.	1. V-belt loose. 2. V-belt worn out.	1. Tighten V-belt (Page 49). 2. Replace V-belt (Page 49).

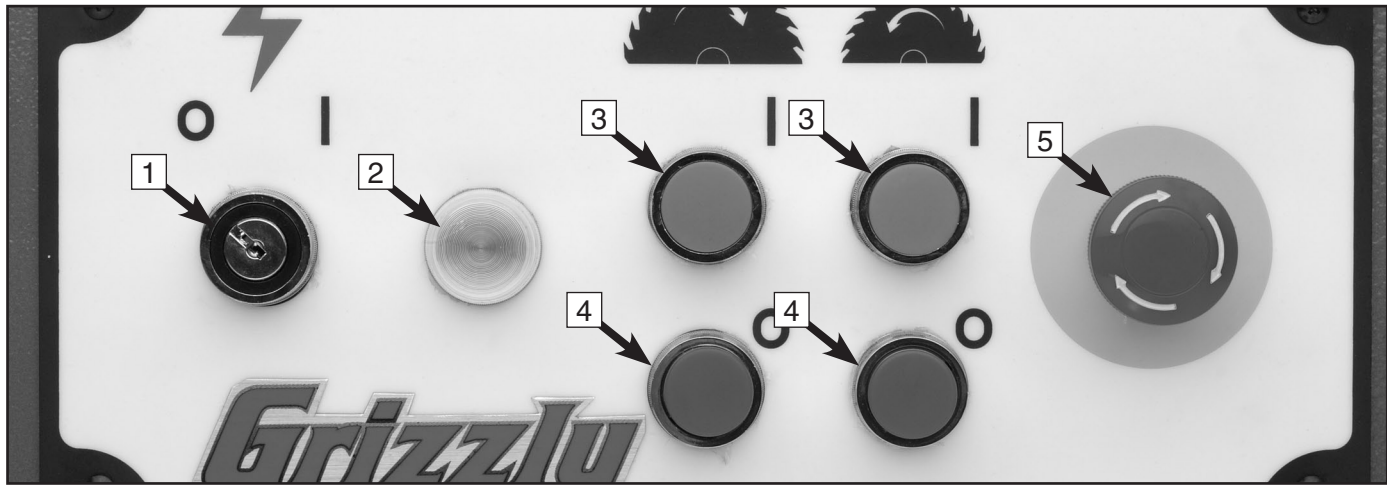
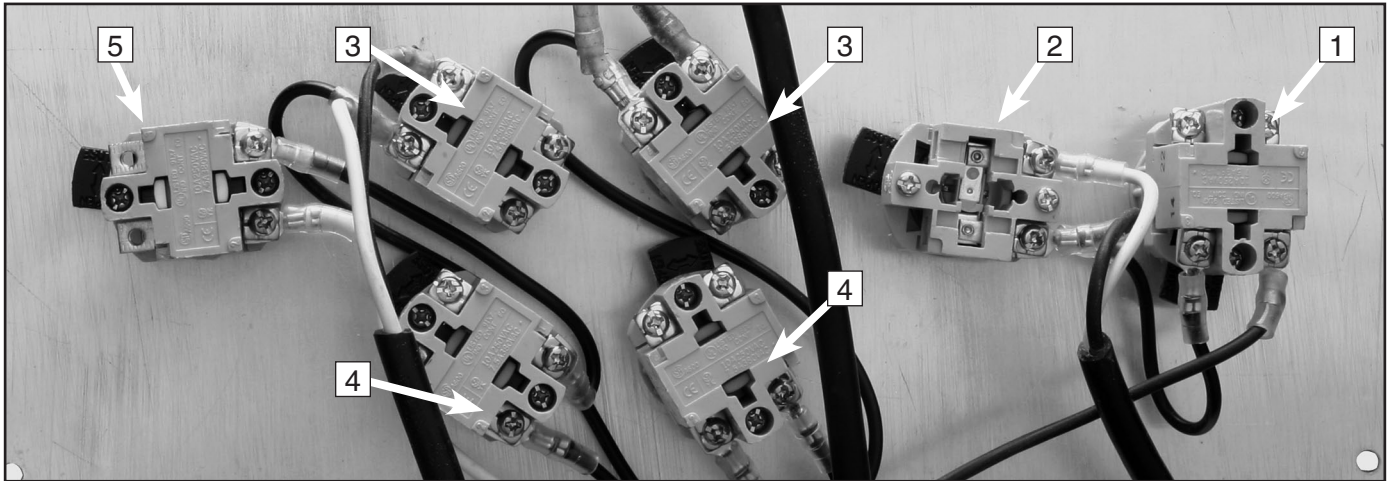


Symptom	Possible Cause	Possible Solution
Loud repetitious noise coming from machine.	1. Pulley setscrews or keys are missing or loose. 2. Motor fan is hitting the cover. 3. V-belts are defective or damaged.	1. Inspect keys and setscrews. Replace or tighten if necessary. 2. Adjust fan cover mounting position, tighten fan, or shim fan cover. 3. Replace V-belts (Page 49).
Vibration when running or cutting.	1. Loose or damaged blade. 2. Worn arbor bearings. 3. Worn or damaged belts.	1. Tighten or replace blade. 2. Check/replace arbor bearings. 3. Replace belts.
Workpiece has burned edges, binds, or kicks back.	1. Sliding table is not parallel to blade. 2. Riving knife is not aligned with the blade. 3. Blade is warped.	1. Make sliding table parallel to the blade (Page 51). 2. Shim the riving knife to align it with the main blade. 3. Replace the blade.
Workpiece has chip out on the bottom edge.	1. Scoring blade height is incorrect. 2. Scoring blade is not aligned with the main blade. 3. Scoring blade kerf does not match the main blade.	1. Adjust the height of the scoring blade. 2. Align the scoring blade (Page 31). 3. Adjust the scoring blade kerf (Page 31).
Sliding table saw does not cut square.	1. Sliding table is not parallel to blade. 2. Rip fence is not parallel to blade. 3. Crosscut fence is not perpendicular to the blade.	1. Adjust the sliding table (Page 51). 2. Adjust the rip fence (Page 24). 3. Adjust the crosscut fence perpendicular to the blade (Page 52).
Fence hits table top when sliding across table.	1. Front rail is too low. 2. Rip fence roller is too low.	1. Raise the rail (Page 24). 2. Adjust the roller (Page 24).
Blade does not reach 90°, or blade does not reach 45°.	1. Blade stop bolts are out of adjustment.	1. Adjust the stop bolts (Page 50).
The rip fence scale is not accurate.	1. The rip fence scale is out of calibration or was not set up correctly.	1. Adjust the rip fence scale (Page 31).
Tilt or blade height handwheels difficult to turn.	1. Lock knob is tight. 2. Gears caked with dust.	1. Release the lock knob. 2. Clean out dust and grease the gears.

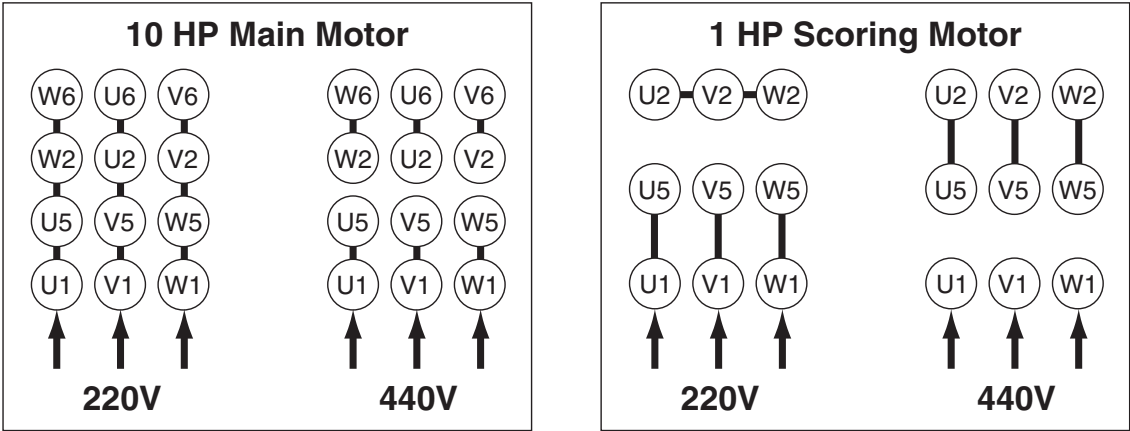
Electrical

REF	PART #	DESCRIPTION
1	P04510001	Key Switch
2	P04510002	Power Lamp
3	P04510003	Switch Button-ON

REF	PART #	DESCRIPTION
4	P04510004	Switch Button-OFF
5	P04510005	Emergency Stop Button

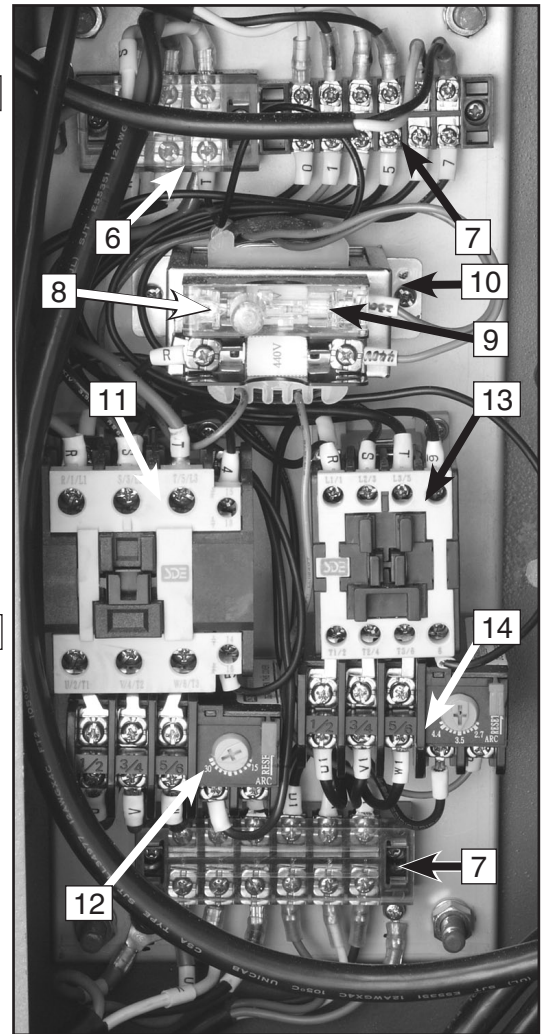
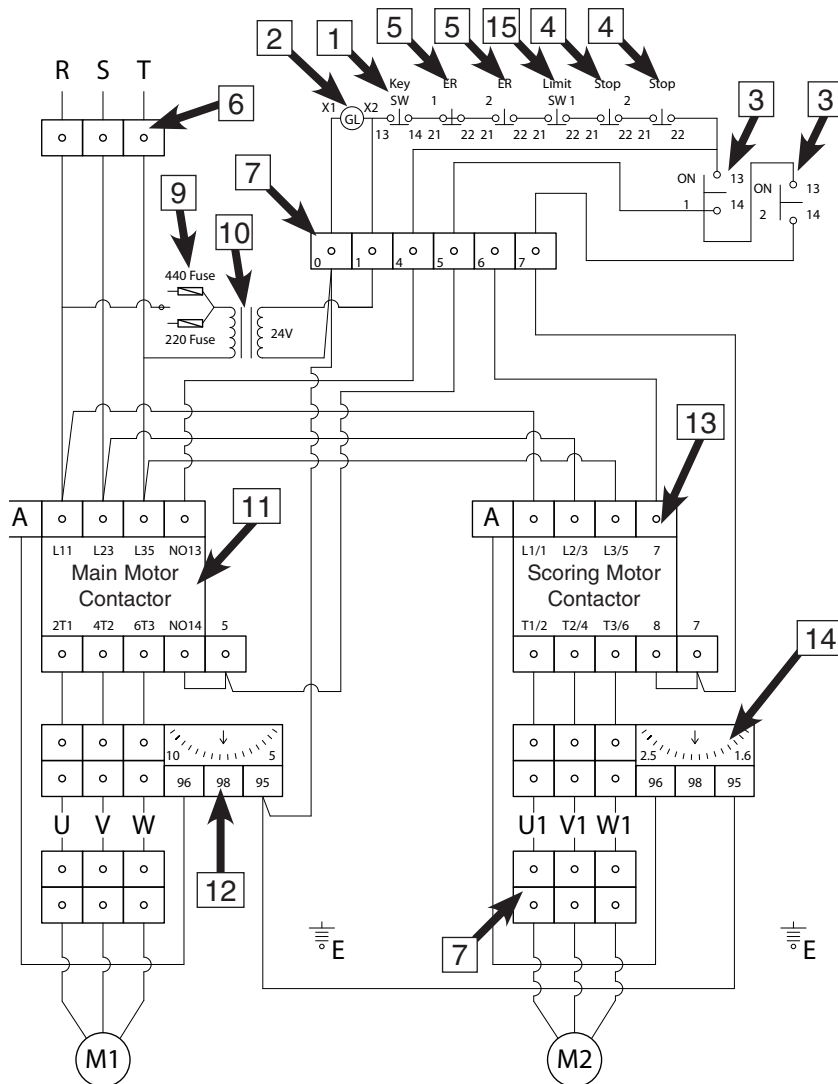


Motor Wiring Diagram



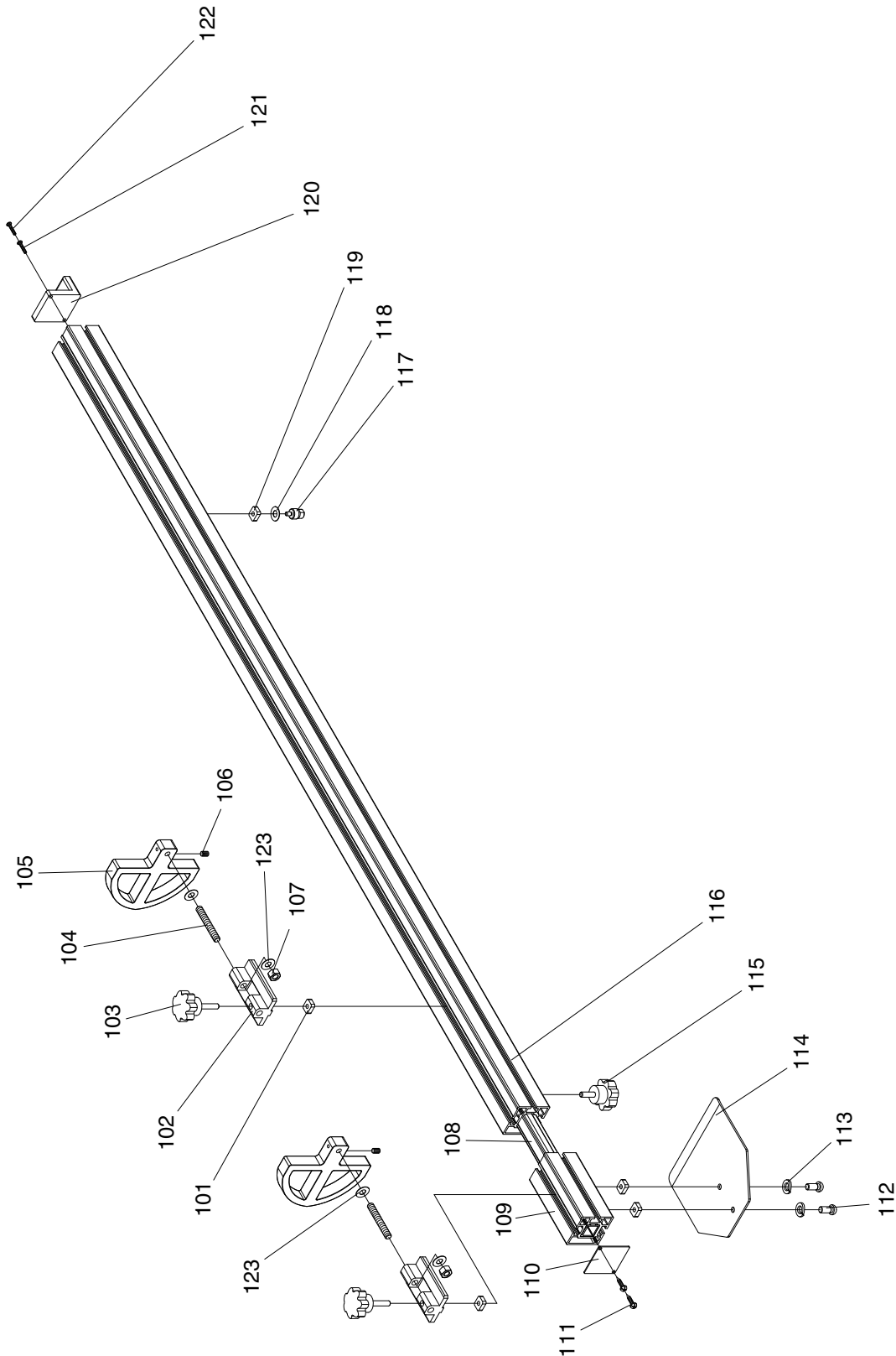
REF	PART #	DESCRIPTION
6	P04510006	Terminal 3 Circuit
7	P04510007	Terminal 6 Circuit
8	P04510008	Fuse Base
9	P04510009	Fuse 250V 10A
10	P04510010	Transformer
11	P04510011	Magnetic Contactor MA-30

REF	PART #	DESCRIPTION
12	P04510012	Over Load RA-30 (15~30A)
13	P04510013	Magnetic Contactor MA-09
14	P04510014	Over Load RA-15 for 220V
14A	P04510014A	Over Load RA-15 for 440V
15	P04510015	Limit Switch



SECTION 8: PARTS

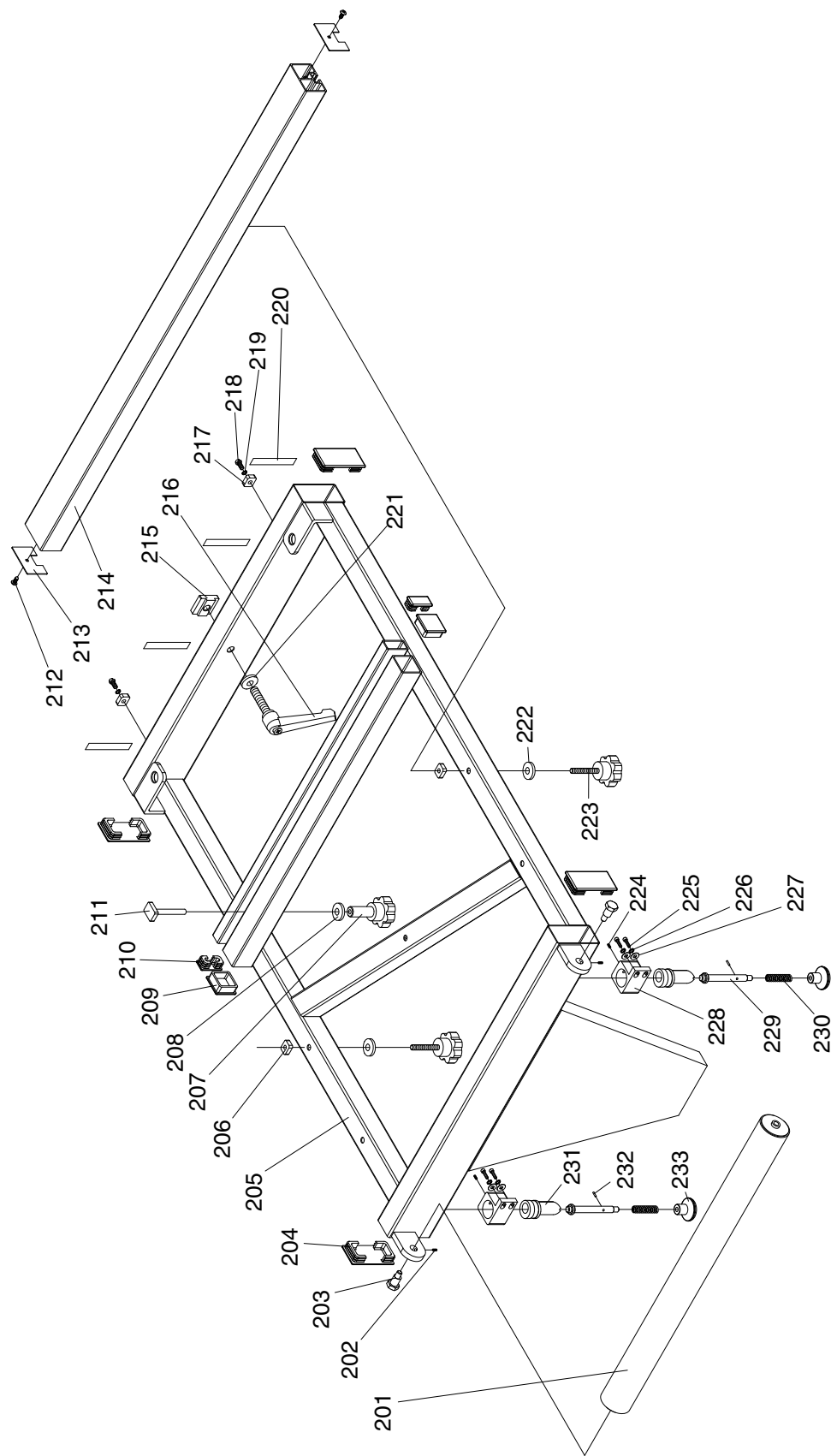
Extension Arm Assembly



REF	PART #	DESCRIPTION
101	P04510101	T-NUT M8-1.25
102	P04510102	STOP BRACKET
103	P04510103	KNOB M8-1.25 X 40
104	P04510104	STUD M10-1.5 X 70
105	P04510105	FLIP STOP
106	PSS01M	SET SCREW M6-1 X 10
107	PLN05M	LOCK NUT M10-1.5
108	P04510108	SQUARE TUBE
109	P04510109	EXT. FENCE
110	P04510110	COVER
111	PHTEK7	TAP SCREW #8 X 3/8"
112	PSBS03M	BTN HD SCR M8-1.25 X 16

REF	PART #	DESCRIPTION
113	PLW04M	LOCK WASHER 8MM
114	P04510114	LOCATE PLATE
115	P04510115	KNOB SCREW M8-1.25 X 25
116	P04510116	SQUARE FENCE
117	P04510117	CNTR STUD M8-1.25 X 10
118	P04510118	FIBER WASHER 10 X 18
119	P04510101	T-NUT M8-1.25
120	P04510120	ROTATE BLOCK
121	PS38M	PHLP HD SCR M4-.7 X 10
122	PS25M	PHLP HD SCR M4-.7 X 35
123	P04510118	FIBER WASHER 10 X 18

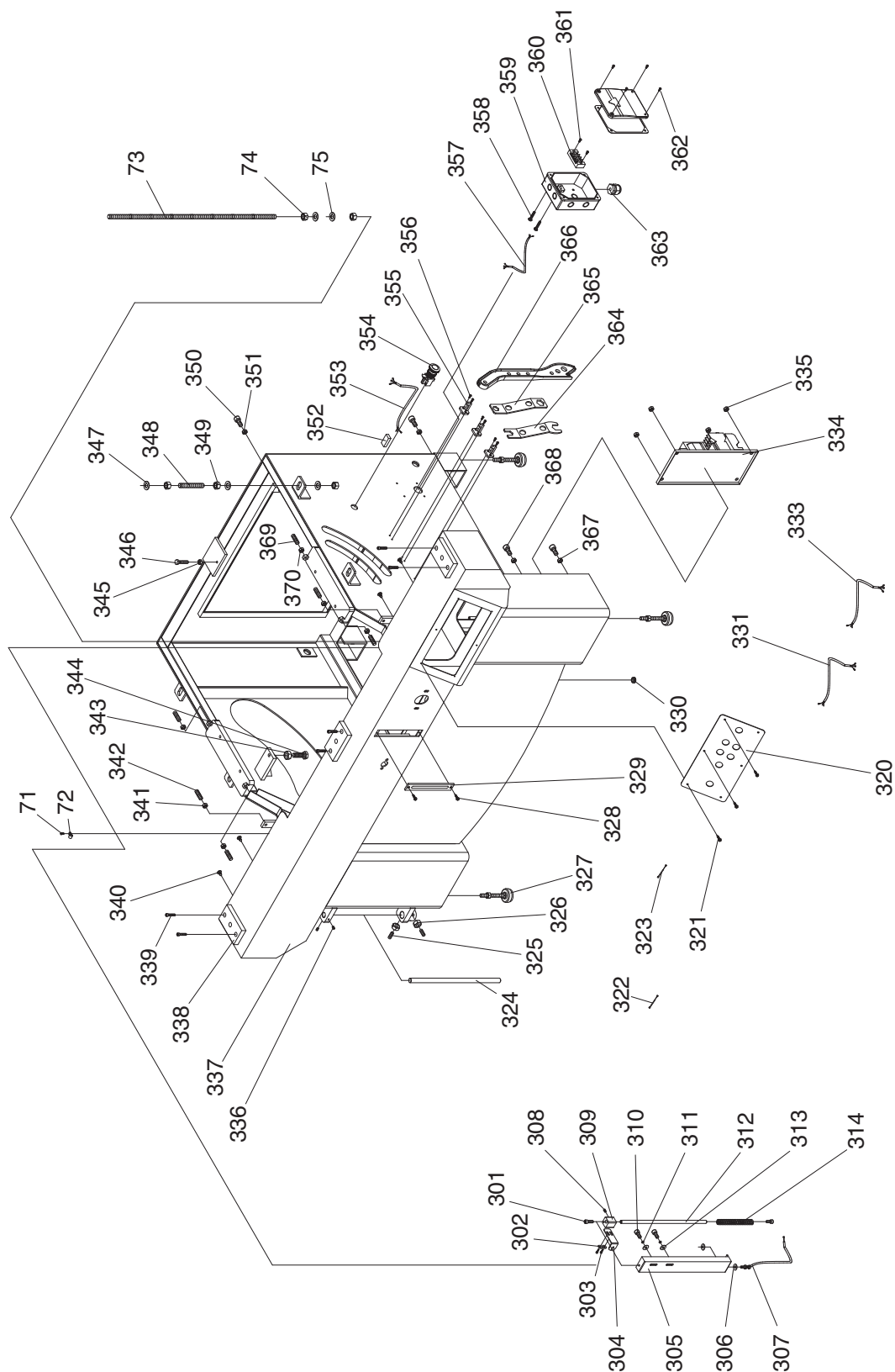
Extension Table Assembly



REF	PART #	DESCRIPTION
201	P04510201	ROLLER
202	PSS01M	SET SCREW M6-1 X 10
203	P04510203	ECCENTRIC
204	P04510204	PLUG 80 X 40
205	P04510205	SUPPORT FRAME
206	P04510101	T-NUT M8-1.25
207	P04510207	KNOB M8-1.25 X 25
208	P04510208	FENDER WASHER 8MM
209	P04510209	PLUG 38 X 38
210	P04510210	PLUG 40 X 20
211	P04510211	T-BOLT M8-1.25 X 60
212	PHTEK7	TAP SCREW #8 X 3/8"
213	P04510213	COVER
214	P04510214	SQUARE BRACE
215	P04510215	T-NUT M12-1.75
216	P04510216	HANDLE M12-1.75 X 55
217	P04510101	T-NUT M8-1.25

REF	PART #	DESCRIPTION
218	PSB115M	BTN HD CAP SCR M6-1 X 16
219	PLW03M	LOCK WASHER 6MM
220	P04510220	PAD
221	P04510221	FENDER WASHER 12MM
222	P04510208	FENDER WASHER 8MM
223	P04510223	KNOB M8-1.25 X 50
224	PSS01M	SET SCREW M6-1 X 10
225	PSB01M	CAP SCREW M6-1 X 16
226	PLW03M	LOCK WASHER 6MM
227	PW03M	FLAT WASHER 6MM
228	P04510228	SET BLOCK
229	P04510229	SET PIN
230	P04510230	COMPRESSION SPRING
231	P04510231	ECCENTRIC BUSHING
232	PRP42M	ROLL PIN 3 X 20
233	P04510233	KNOB M8-1.25

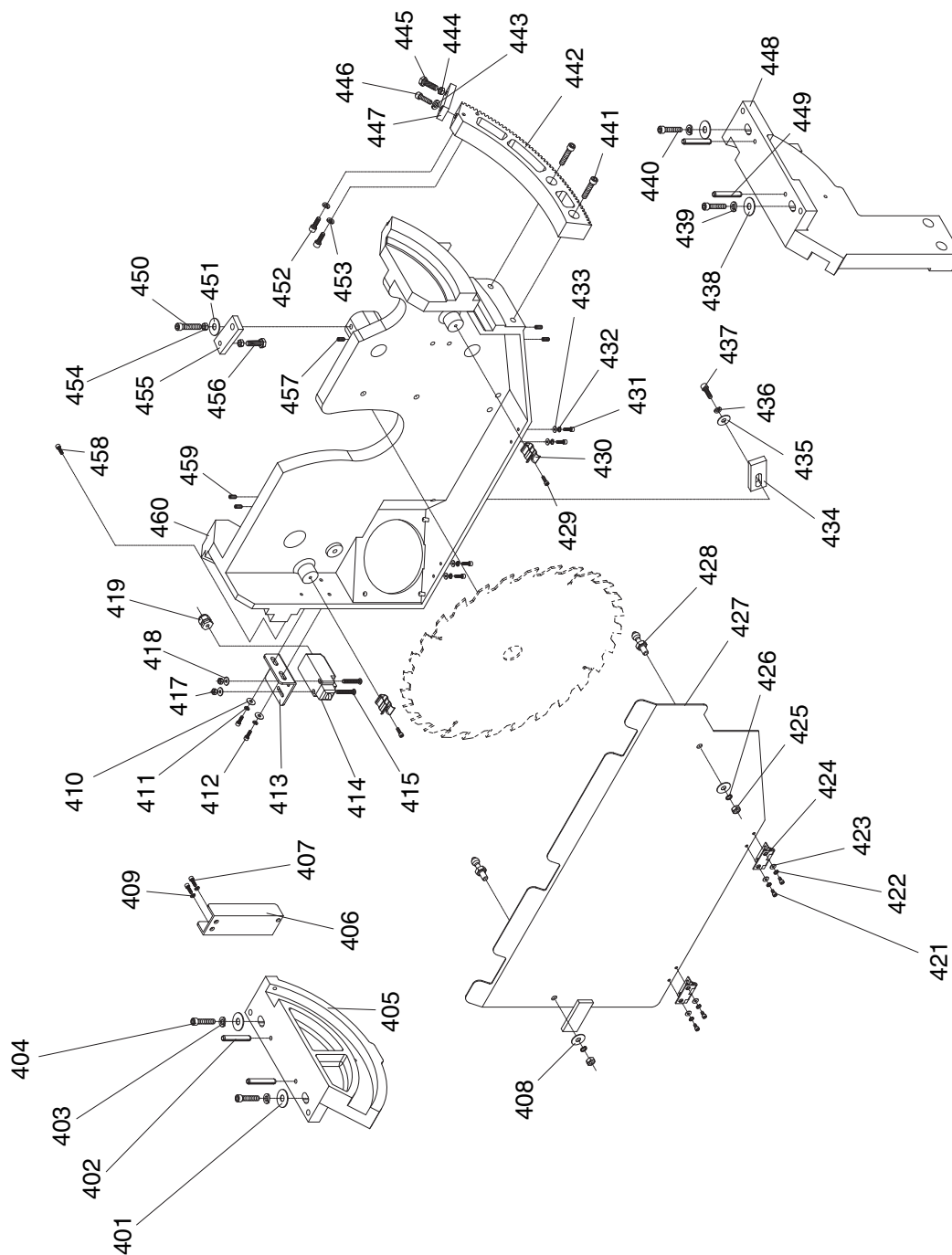
Base Assembly



REF	PART #	DESCRIPTION
301	PSB50M	CAP SCREW M5-.8 X 10
302	P04510302	FENDER WASHER 5MM
303	PS09M	PHLP HD SCR M5-.8 X 10
304	P04510304	POINTER
305	P04510305	FIX PLATE
306	PW03M	FLAT WASHER 6MM
307	P04510307	STEEL WIRE
308	PSS05M	SET SCREW M5-.8 X 10
309	P04510309	INDICATOR BLOCK
310	PSB26M	CAP SCREW M6-1 X 12
311	PLW03M	LOCK WASHER 6MM
312	P04510312	SHAFT
313	PW03M	FLAT WASHER 6MM
314	P04510314	COMPRESSION SPRING
320	P04510320	CONTROL PANEL FACE
321	PHTEK7	TAP SCREW #8 X 3/8"
322	P04510322	CORD
323	P04510323	CORD
324	P04510324	SHAFT
325	PSS10M	SET SCREW M10-1.5 X 20
326	PN02M	HEX NUT M10-1.5
327	P04510327	ADJUST FOOT M16 X 100
328	PHTEK7	TAP SCREW #8 X 3/8"
329	P04510329	TILT SCALE
330	P04510330	PLUG
331	P04510331	CORD
333	P04510333	CORD
334	P04510334	ELECTRIC PANEL
335	PFN02M	FLANGE NUT M6-1
336	PSS04M	SET SCREW M6-1 X 12
337	P04510337	MACHINE BODY
338	P04510338	LOCATE BLOCK
339	PSB11M	CAP SCREW M8-1.25 X 16
340	PHTEK7	TAP SCREW #8 X 3/8"
341	PN02M	HEX NUT M10-1.5

REF	PART #	DESCRIPTION
342	PSS84M	SET SCREW M10-1.5 X 35
343	PN09M	HEX NUT M12-1.75
344	PB33M	HEX BOLT M12-1.75 X 50
345	PN03M	HEX NUT M8-1.25
346	PB26M	HEX BOLT M8-1.25 X 30
347	P04510347	FENDER WASHER M14 X 30
348	P04510348	HEX BOLT M14-2 X 100
349	PN32M	HEX NUT M14-2
350	PSB07M	CAP SCREW M6-1 X 30
351	PLN03M	LOCK NUT M6-1
352	P04510352	WIRE CONNECTOR
353	P04510353	CORD
354	P0451005	EMERGENCY STOP BUTTON
355	P04510355	HANGER
356	PS40M	PHLP HD SCR M5-.8 X 16
357	P04510357	POWER CORD
358	PSBS05M	BTN HD CAP SCR M6-1 X 20
359	P04510359	POWER BOX
360	P04510360	TERMINAL
361	PS05M	PHLP HD SCR M5-.8 X 8
362	PSBS06M	BTN HD CAP SCR M5-.8 X 12
363	P04510363	STRAIN RELIEF M20
364	P04510364	ARBOR WRENCH 24,19MM
365	P04510365	ARBOR WRENCH 24,19MM
366	P04510366	PUSH STICK
367	PLN03M	LOCK NUT M6-1
368	PSB02M	CAP SCREW M6-1 X 20
369	PSS39M	SET SCREW M10-1.5 X 50
370	PN02M	HEX NUT M10-1.5
371	PFS07M	FLANGE SCREW M5-.8 X 10
372	P04510372	WIRE CLIP 5/16"
373	P04510373	STUD M12-1.75 X 720
374	PN09M	HEX NUT M12-1.75
375	PW06M	FLAT WASHER 12MM

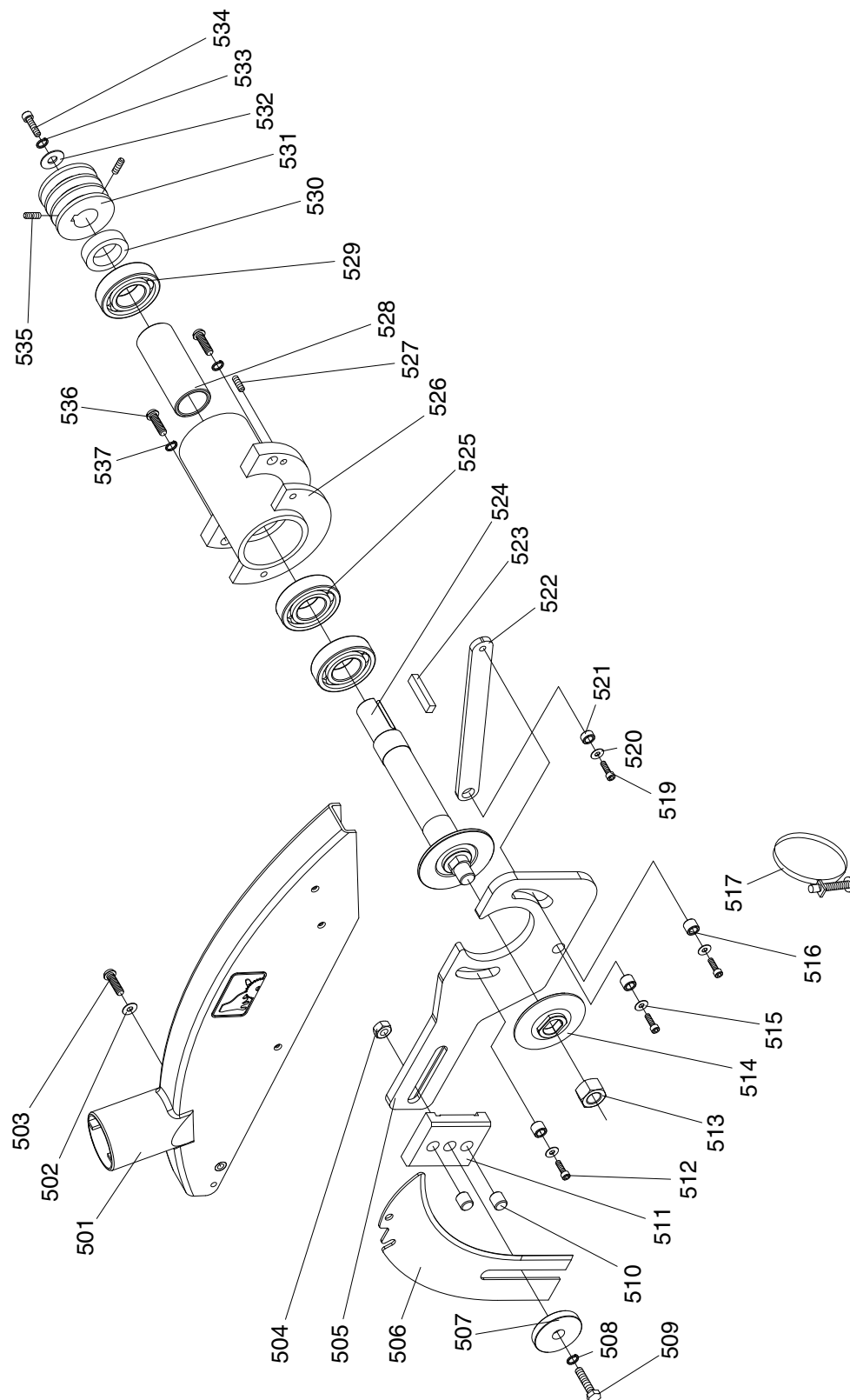
Blade Assembly



REF	PART #	DESCRIPTION
401	PW04M	FLAT WASHER 10MM
402	PRP58M	ROLL PIN 6 X 45
403	PLW06M	LOCK WASHER 10MM
404	PSB84M	CAP SCREW M10-1.5 X 35
405	P04510405	LEFT TRUNNION BRACKET
406	P04510406	LOCATE PLATE
407	PSB26M	CAP SCREW M6-1 X 12
408	PW01M	FLAT WASHER 8MM
409	PLW03M	LOCK WASHER 6MM
410	PW03M	FLAT WASHER 6MM
411	PLW03M	LOCK WASHER 6MM
412	PSB04M	CAP SCREW M6-1 X 10
413	P04510413	FIX PLATE
414	P04510414	DOOR SAFETY SWITCH
415	PS25M	PHLP HD SCR M4-.7 X 35
417	PN04M	HEX NUT M4-.7
418	PW05M	FLAT WASHER 4MM
419	P04510419	STRAIN RELIEF PG11
421	P04510421	CAP SCREW M5-.8 X 5
422	PLW01M	LOCK WASHER 5MM
423	PW02M	FLAT WASHER 5MM
424	P04510424	HINGE
425	PN03M	HEX NUT M8-1.25
426	PLW04M	LOCK WASHER 8MM
427	P04510427	COVER
428	P04510428	STUD LATCH
429	PSB50M	CAP SCREW M5-.8 X 10
430	P04510430	CATCH
431	PSB50M	CAP SCREW M5-.8 X 10

REF	PART #	DESCRIPTION
432	PLW01M	LOCK WASHER 5MM
433	PW02M	FLAT WASHER 5MM
434	P04510434	FIX BLOCK
435	P04510208	FENDER WASHER 8MM
436	PLW04M	LOCK WASHER 8MM
437	PSB31M	CAP SCREW M8-1.25 X 25
438	PW04M	FLAT WASHER 10MM
439	PLW06M	LOCK WASHER 10MM
440	PSB84M	CAP SCREW M10-1.5 X 35
441	PSB72M	CAP SCREW M10-1.5 X 30
442	P04510442	SEGMENT RACK
443	PLW04M	LOCK WASHER 8MM
444	PN03M	HEX NUT M8-1.25
445	PB26M	HEX BOLT M8-1.25 X 30
446	PSB14M	CAP SCREW M8-1.25 X 20
447	P04510447	LOCATE BLOCK
448	P04510448	RIGHT TRUNNION BRACKET
449	PRP58M	ROLL PIN 6 X 45
450	PSB12M	CAP SCREW M8-1.25 X 40
451	PW01M	FLAT WASHER 8MM
452	PSB07M	CAP SCREW M6-1 X 30
453	PLW03M	LOCK WASHER 6MM
454	PN03M	HEX NUT M8-1.25
455	P04510455	LOCATE BLOCK
456	PB28M	HEX BOLT M8-1.25 X 60
457	PSS06M	SET SCREW M8-1.25 X 16
458	PSB33M	CAP SCREW M5-.8 X 12
459	PSS75M	SET SCREW M10-1.5 X 16
460	P04510460	CHANNEL BASE

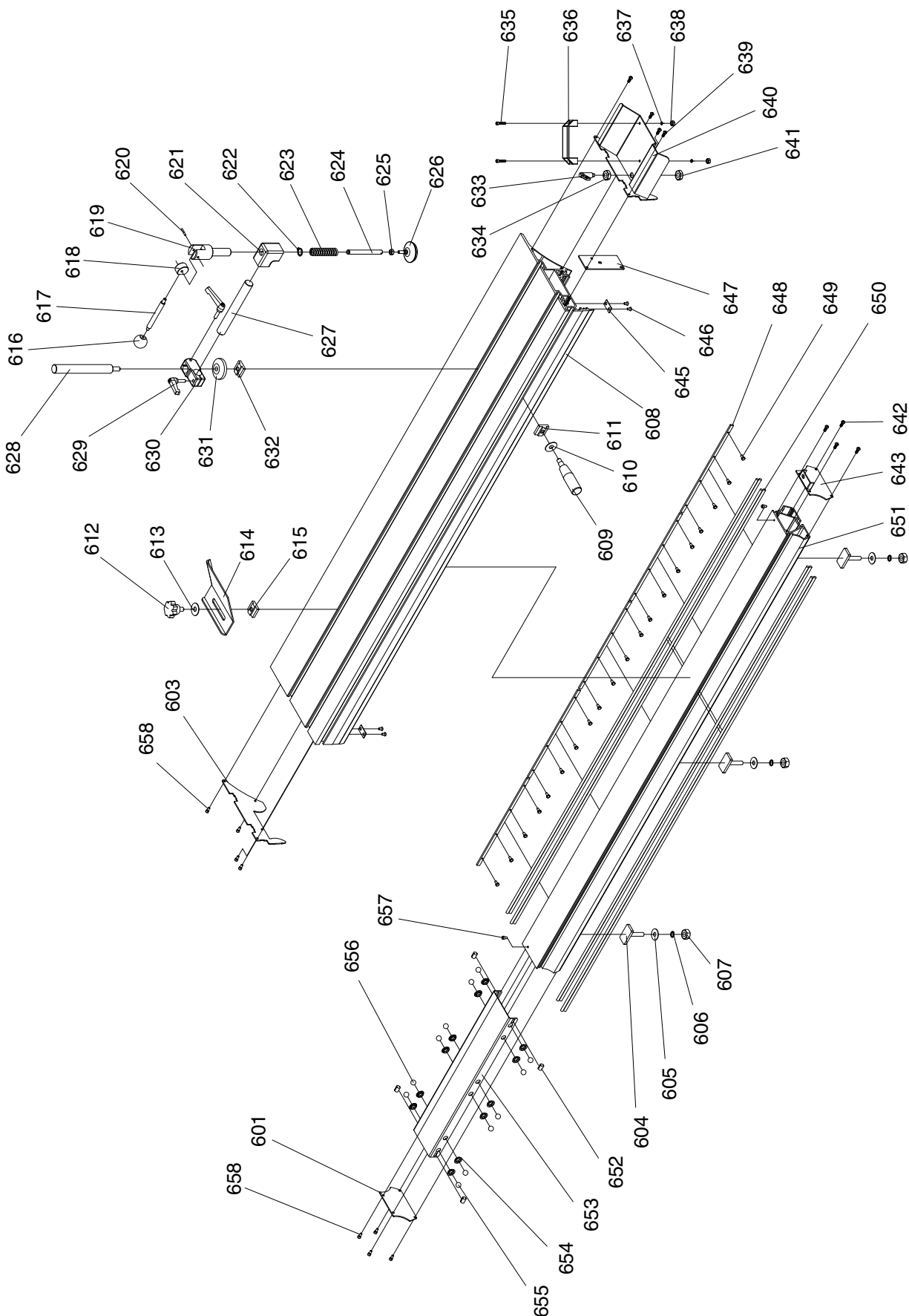
Arbor and Dust Hood Assembly



REF	PART #	DESCRIPTION
501	P04510501	BLADE GUARD
502	P04510208	FENDER WASHER 8MM
503	PSBS07M	BTN HD SCR M8-1.25 X 40
504	PN09M	HEX NUT M12-1.75
505	P04510505	LOCATE PLATE
506	P04510506	RIVING KNIFE
507	P04510507	SPECIAL WASHER 12MM
508	PLW05M	LOCK WASHER 12MM
509	PB101M	HEX BOLT M12-1.75 X 40
510	P04510510	LOCATING PIN
511	P04510511	FIX BLOCK
512	PSB14M	CAP SCREW M8-1.25 X 20
513	P04510513	HEX NUT M16-2 LH
514	P04510514	ARBOR FLANGE
515	P04510208	FENDER WASHER 8MM
516	P04510516	BUSHING
517	P04510517	HOSE CLAMP 2-1/2"
519	PSB14M	CAP SCREW M8-1.25 X 20

REF	PART #	DESCRIPTION
520	P04510208	FENDER WASHER 8MM
521	P04510521	BUSHING
522	P04510522	LINK PLATE
523	P04510523	KEY 8 X 7 X 35
524	P04510524	MAIN ARBOR 1"
525	P6206	BALL BEARING 6206ZZ
526	P04510526	MAIN HOUSING
527	PSS06M	SET SCREW M8-1.25 X 16
528	P04510528	BUSHING
529	P6206	BALL BEARING 6206ZZ
530	P04510530	LOCATE RING
531	P04510531	ARBOR PULLEY
532	P04510208	FENDER WASHER 8MM
533	PLW04M	LOCK WASHER 8MM
534	PSB31M	CAP SCREW M8-1.25 X 25
535	PSS11M	SET SCREW M6-1 X 16
536	PSBS08M	BTN HD SCR M10-1.5 X 35
537	PLW06M	LOCK WASHER 10MM

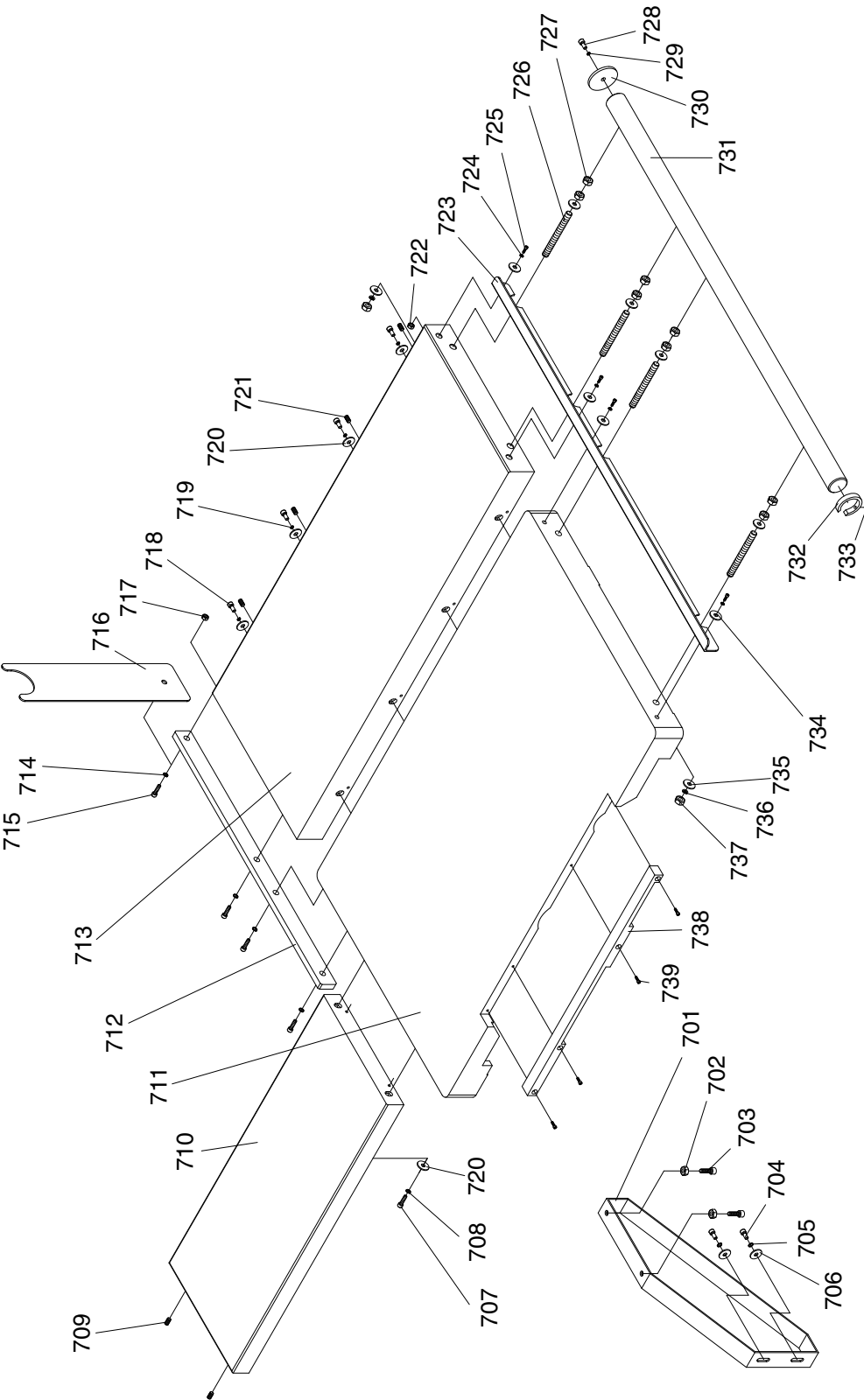
Sliding Table Assembly



REF	PART #	DESCRIPTION
601	P04510601	LOCATE PLATE
602	PSB115M	BTN HD CAP SCR M6-1 X 16
603	P04510603	PROTECT PLATE
604	P04510604	T-BOLT M12-1.75 X 60
605	PW06M	FLAT WASHER 12MM
606	PLW05M	LOCK WASHER 12MM
607	PN09M	HEX NUT M12-1.75
608	P04510608	SLIDING TABLE SET
609	P04510609	HANDLE M12-1.75
610	PW06M	FLAT WASHER 12MM
611	P04510215	T-NUT M12-1.75
612	P04510612	KNOB M12-1.75 X 20
613	PW06M	FLAT WASHER 12MM
614	P04510614	EDGE SHOE PLATE
615	P04510215	T-NUT M12-1.75
616	P04510616	BALL KNOB M8-1.25
617	P04510617	HANDLE SHAFT
618	P04510618	CAM
619	P04510619	CAM BRACKET
620	PRP32M	ROLL PIN 6 X 40
621	P04510621	LOCATE BLOCK
622	PR03M	EXT RETAINING RING 12MM
623	P04510623	COMPRESSION SPRING
624	P04510624	SHAFT
625	PN02	HEX NUT 5/16-18
626	P04510626	LARGE WASHER
627	P04510627	SHAFT
628	P04510628	SHAFT
629	P04510629	LOCK HANDLE

REF	PART #	DESCRIPTION
630	P04510630	BLOCK
631	P04510631	DISC-GASKET
632	P04510215	T-NUT M12-1.75
633	P04510633	PIN LOCK
634	PN05M	HEX NUT M16-1.5
635	PSB11M	CAP SCREW M8-1.25 X 16
636	P04510636	HANDLE
637	PLW04M	LOCK WASHER 8MM
638	PN03M	HEX NUT M8-1.25
639	PSB115M	BTN HD CAP SCR M6-1 X 16
640	P04510640	RIGHT END PLATE
641	PN05M	HEX NUT M16-1.5
642	PSB115M	BTN HD CAP SCR M6-1 X 16
643	P04510643	LOCK PLATE
645	P04510645	HORIZ. LOCATE PLATE
646	PFH02M	FLAT HD SCR M6-1 X 12
647	P04510647	VERTICAL LOCATE PLATE
648	P04510648	ADJUST LOCATE RACK
649	PB02M	HEX BOLT M6-1 X 12
650	P04510650	STEEL RAIL
651	P04510651	BOTTOM BASE
652	P04510652	BUMPER
653	P04510653	SLIDING BOTTOM
654	P04510654	STEEL BALL SLEEVE
655	P04510655	STEEL BALL 16MM
656	P04510656	STEEL BALL 16.2MM
657	PSB04M	CAP SCREW M6-1 X 10
658	PSBS11M	BTN HD CAP SCR M6-1X10

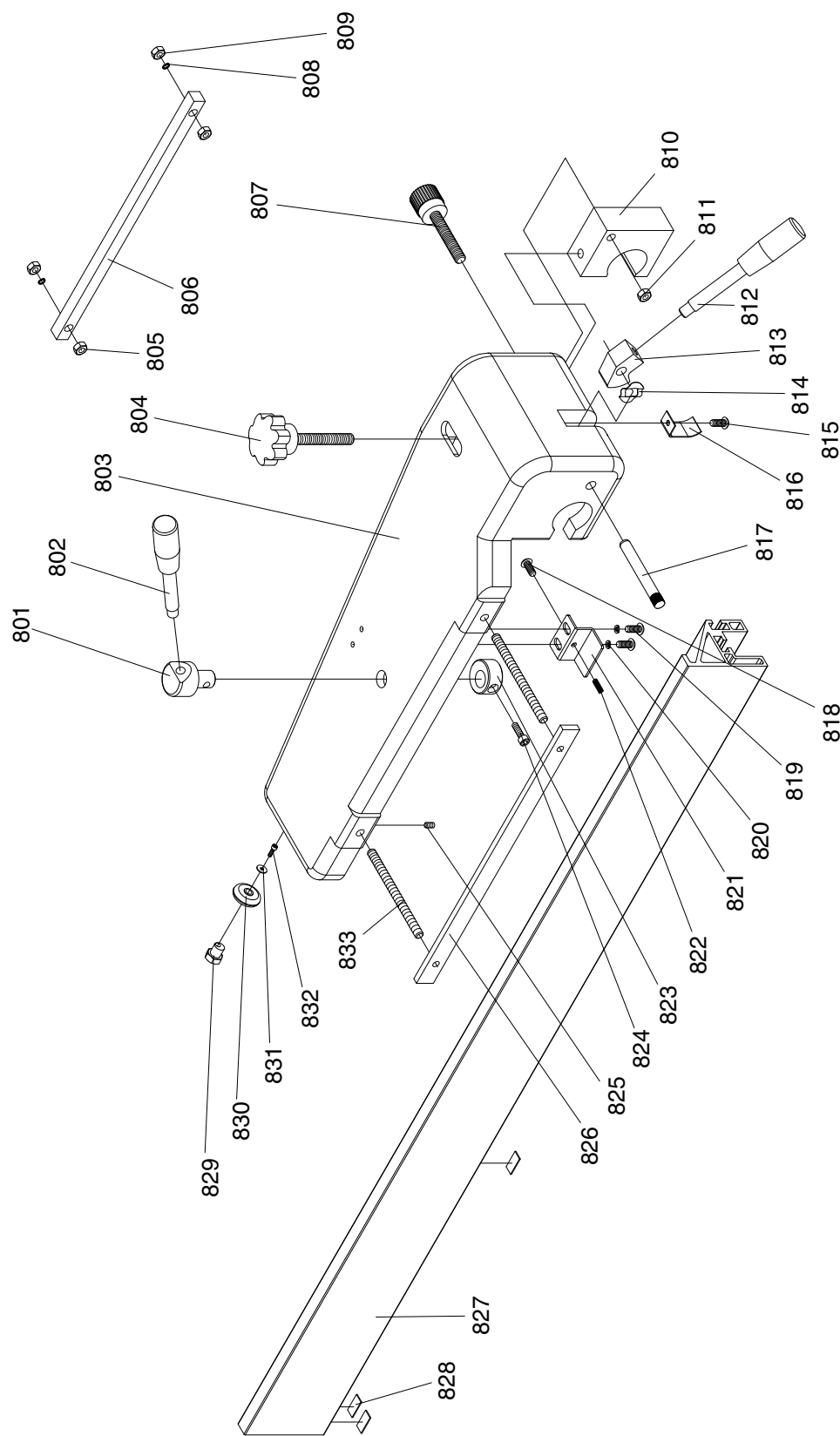
Table Assembly



REF	PART #	DESCRIPTION
701	P04510701	SUPPORT BRACE
702	PN03M	HEX NUT M8-1.25
703	PSB14M	CAP SCREW M8-1.25 X 20
704	PSB11M	CAP SCREW M8-1.25 X 16
705	PLW04M	LOCK WASHER 8MM
706	P04510208	FENDER WASHER 8MM
707	PSB61M	CAP SCREW M10-1.5 X 20
708	PLW06M	LOCK WASHER 10MM
709	PSS04M	SET SCREW M6-1 X 12
710	P04510710	OUTFEED EXT. TABLE
711	P04510711	TABLE
712	P04510712	LEFT SUPPORT PLATE
713	P04510713	EXTENSION TABLE
714	PLW06M	LOCK WASHER 10MM
715	PSB72M	CAP SCREW M10-1.5 X 30
716	P04510716	HOSE SUPPORT PLATE
717	PN02M	HEX NUT M10-1.5
718	PSB61M	CAP SCREW M10-1.5 X 20
719	PLW06M	LOCK WASHER 10MM
720	PW04M	FLAT WASHER 10MM

REF	PART #	DESCRIPTION
721	PSS04M	SET SCREW M6-1 X 12
722	PN02M	HEX NUT M10-1.5
723	P04510723	SCALE
724	PLW06M	LOCK WASHER 10MM
725	PSB64M	CAP SCREW M10-1.5 X 20
726	P04510726	STUD M12-1.75 X 115
727	PN09M	HEX NUT M12-1.75
728	PSB11M	CAP SCREW M8-1.25 X 16
729	PLW04M	LOCK WASHER 8MM
730	P04510730	END WASHER
731	P04510731	ROUND RAIL
732	P04510732	RING STOP
733	PSS01M	SET SCREW M6-1 X 10
734	PW04M	FLAT WASHER 10MM
735	PW06M	FLAT WASHER 12MM
736	PLW05M	LOCK WASHER 12MM
737	PN09M	HEX NUT M12-1.75
738	P04510738	TABLE INSERT
739	PSB38M	CAP SCREW M5-.8 X 25

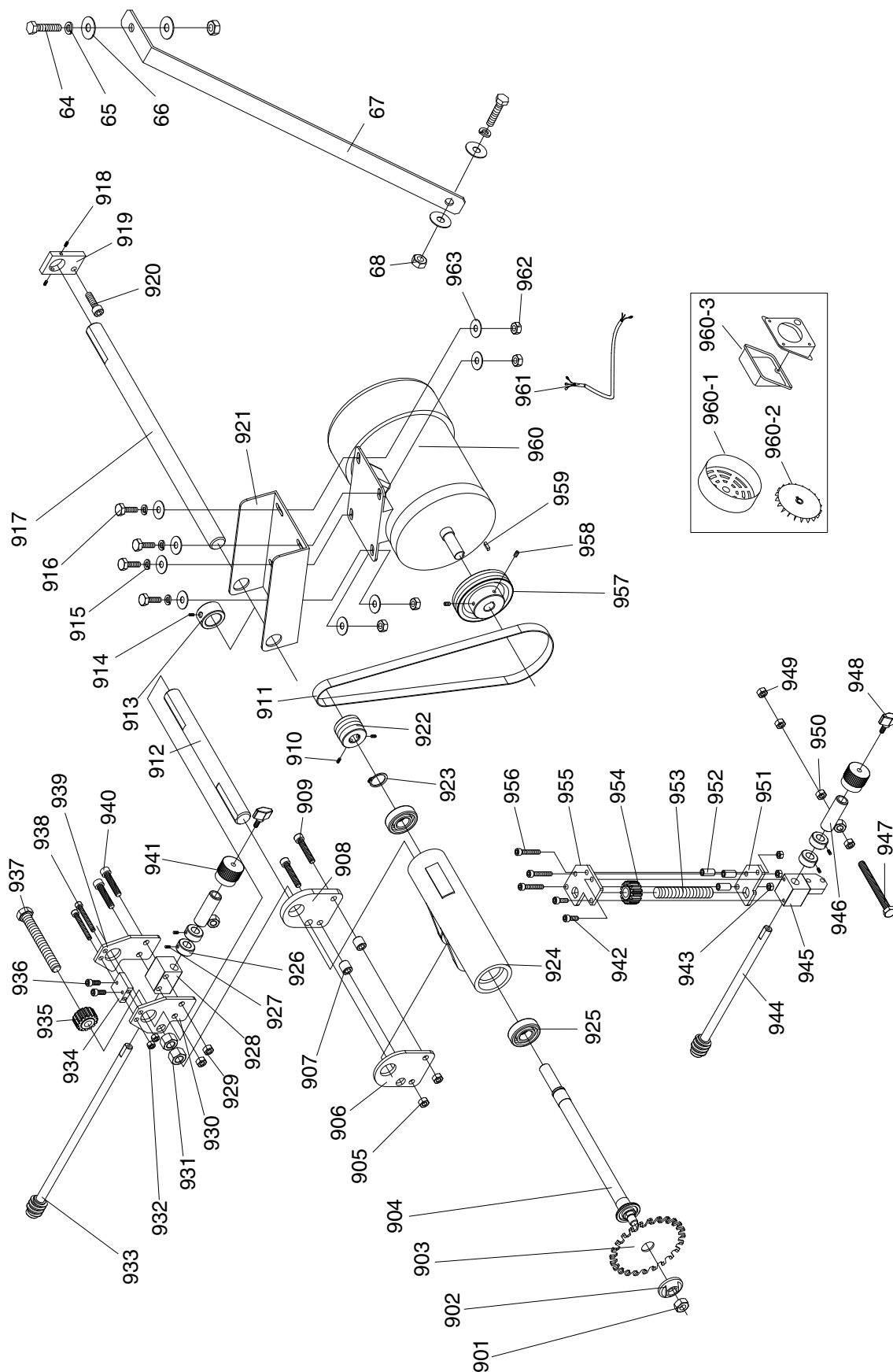
Fence Assembly



REF	PART #	DESCRIPTION
801	P04510801	ROTATE SHAFT
802	P04510802	HANDLE M10-1.5 X 12
803	P04510803	RIP FENCE HOUSING
804	P04510804	KNOB M10-1.5 X 70
805	PN03M	HEX NUT M8-1.25
806	P04510806	LOCATE PLATE
807	P04510807	MICRO-ADJUST KNOB
808	PLW04M	LOCK WASHER 8MM
809	PN03M	HEX NUT M8-1.25
810	P04510810	LOCATE BLOCK
811	PLN05M	LOCK NUT M10-1.5
812	P04510812	HANDLE M10-1.5 X 12
813	P04510813	CAM
814	P04510814	WAVE WASHER 10 X 15
815	PFS12Myy	FLANGE SCREW M5-.8 X 12
816	P04510816	SPRING PIECE
817	P04510817	PIN

REF	PART #	DESCRIPTION
818	PSB115M	BTN HD CAP SCR M6-1 X 16
819	PSBS09M	BTN HD CAP SCR M6-1 X 12
820	PW03M	FLAT WASHER 6MM
821	P04510821	PLATE
822	P04510822	COMPRESSION SPRING
823	P04510823	CAM
824	PSB11M	CAP SCREW M8-1.25 X 16
825	PSS05M	SET SCREW M5-.8 X 10
826	P04510826	CLAMP PLATE
827	P04510827	FENCE PLATE
828	P04510828	BEARING PAD
829	P04510829	ECCENTRIC SHAFT
830	P04510830	PLASTIC ROLLER
831	PW03M	FLAT WASHER 6MM
832	PSB01M	CAP SCREW M6-1 X 16
833	P04510833	STUD M8-1.25 X 110

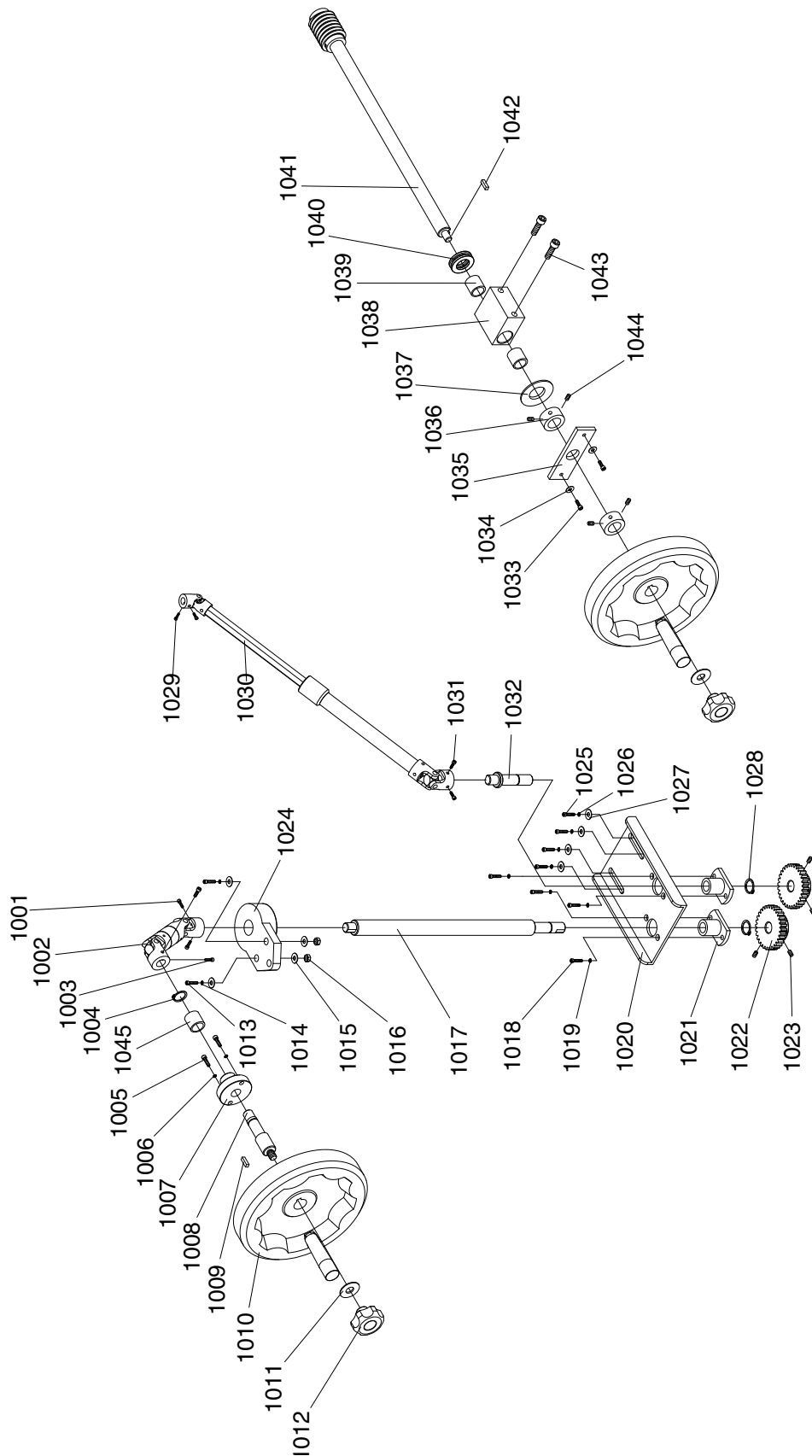
Motor Assembly



REF	PART #	DESCRIPTION
901	PN09M	HEX NUT M12-1.75
902	P04510902	SCORING FLANGE
903	P04510903	SCORING BLADE 22MM
904	P04510904	SCORING ARBOR 22MM
905	PLN04M	LOCK NUT M8-1.25
906	P04510906	FIX PLATE
907	P04510907	BUSHING
908	P04510908	FIX PLATE
909	PSB12M	CAP SCREW M8-1.25 X 40
910	PSS01M	SET SCREW M6-1 X 10
911	P04510911	FLAT BELT 15 X 787
912	P04510912	SHAFT
913	P04510913	COLLAR
914	PSS01M	SET SCREW M6-1 X 10
915	PLW04M	LOCK WASHER 8MM
916	PB07M	HEX BOLT M8-1.25 X 25
917	P04510917	SHAFT
918	PSS01M	SET SCREW M6-1 X 10
919	P04510919	LOCATE PLATE
920	PSB130M	CAP SCREW M10-1.5 X 16
921	P04510921	MOTOR PLATE
922	P04510922	ARBOR PULLEY
923	PR09M	EXT RETAINING RING 20MM
924	P04510924	SCORING HOUSING
925	P6204	BALL BEARING 6204ZZ
926	P04510926	COLLAR
927	PSS02M	SET SCREW M6-1 X 6
928	P04510928	FIX BLOCK
929	PLN04M	LOCK NUT M8-1.25
930	P04510930	FIX PLATE
931	PN32M	HEX NUT M14-2
932	PLN03M	LOCK NUT M6-1
933	P04510933	ADJUST SHAFT
934	P04510934	FIX BLOCK
935	P04510935	GEAR 15T
936	PSB01M	CAP SCREW M6-1 X 16

REF	PART #	DESCRIPTION
937	PB100M	HEX BOLT M14-2 X 100
938	PSB37M	CAP SCREW M6-1 X 50
939	P04510939	FIX PLATE
940	PSB60M	CAP SCREW M8-1.25 X 55
941	P04510941	ADJUST KNOB
942	PSB01M	CAP SCREW M6-1 X 16
943	PLN03M	LOCK NUT M6-1
944	P04510944	ADJUST SHAFT
945	P04510945	FIX BRACKET
946	P04510946	SLEEVE
947	PB45M	HEX BOLT M8-1.25 X 100
948	P04510948	KNOB M6-1 X 20
949	PLN04M	LOCK NUT M8-1.25
950	PN03M	HEX NUT M8-1.25
951	P04510951	FIX PLATE
952	P04510952	BUSHING
953	P04510953	LEADSCREW
954	P04510935	GEAR 15T
955	P04510955	FIX PLATE
956	PSB29M	CAP SCREW M6-1 X 40
957	P04510957	MOTOR PULLEY
958	PSS01M	SET SCREW M6-1 X 10
959	PK23M	KEY 5 X 5 X 25
960	P04510960	SCORING MOTOR 1HP
960-1	P04510960-1	FAN COVER
960-2	P04510960-2	MOTOR FAN
960-3	P04510960-3	MOTOR WIRING BOX
961	P04510961	SCORING MOTOR CORD
962	PN03M	HEX NUT M8-1.25
963	P04510208	FENDER WASHER 8MM
964	PB01M	HEX BOLT M10-1.5 X 30
965	PLW06M	LOCK WASHER 10MM
966	PW04M	FLAT WASHER 10MM
967	P04510967	FIX PLATE
968	PN02M	HEX NUT M10-1.5

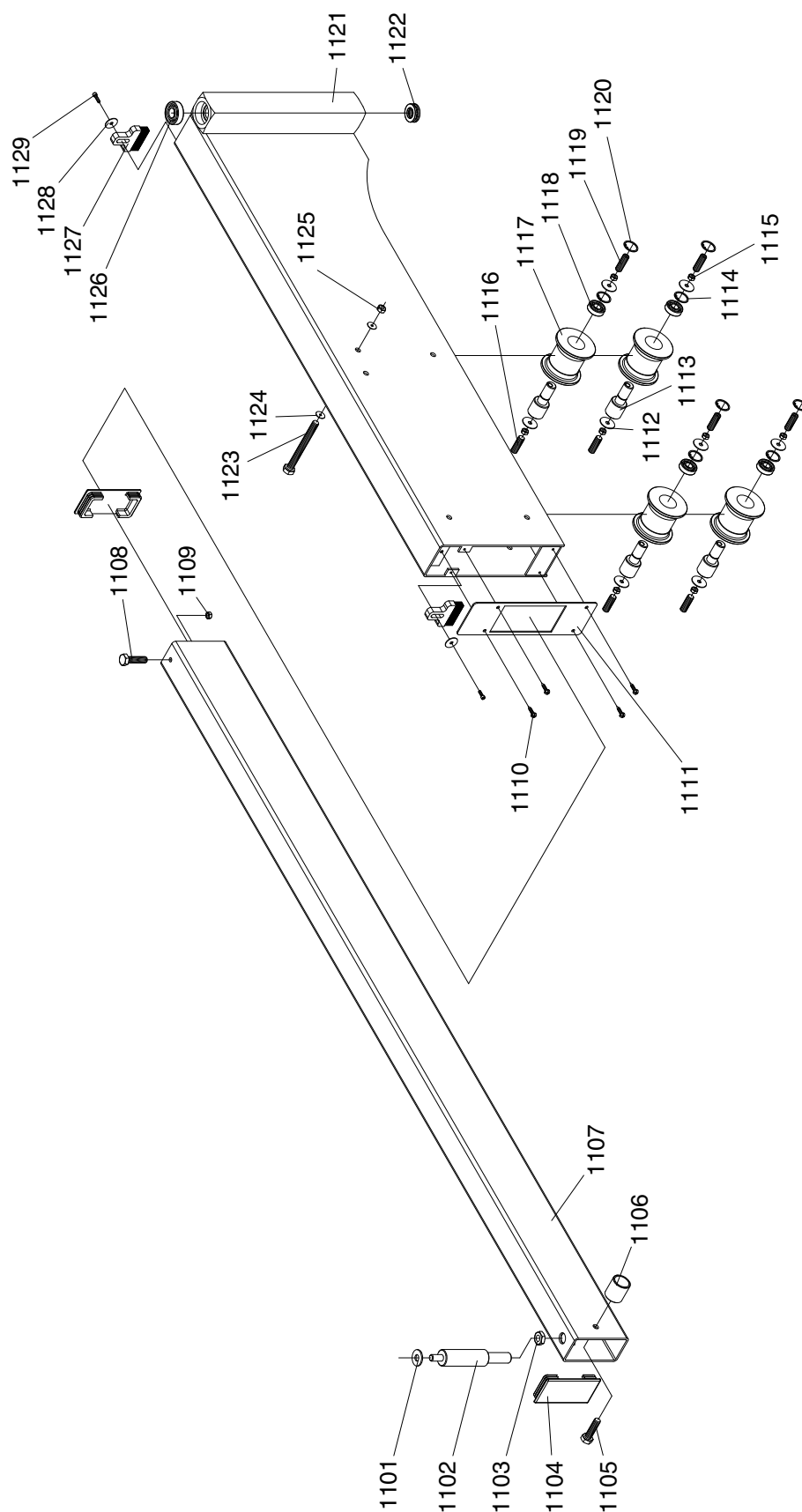
Blade Adjustment Assembly



REF	PART #	DESCRIPTION
1001	PSB04M	CAP SCREW M6-1 X 10
1002	P04511002	FREE JOINT
1003	PSB04M	CAP SCREW M6-1 X 10
1004	PR05M	EXT RETAINING RING 15MM
1005	PSB11M	CAP SCREW M8-1.25 X 16
1006	PLW04M	LOCK WASHER 8MM
1007	P04511007	LOCATE RING
1008	P04511008	HAND WHEEL SHAFT
1009	PK25M	KEY 7 X 7 X 20
1010	P04511010	HAND WHEEL 8"
1011	PW04M	FLAT WASHER 10MM
1012	P04511012	KNOB M10-1.5
1013	PSB40M	CAP SCREW M8-1.25 X 35
1014	PLW04M	LOCK WASHER 8MM
1015	P0451208	FENDER WASHER 8MM
1016	PLN04M	LOCK NUT M8-1.25
1017	P04511017	LONG SHAFT
1018	PSB58M	CAP SCREW M8-1.25 X 12
1019	PLW04M	LOCK WASHER 8MM
1020	P04511020	LOCATE PLATE
1021	P04511021	BEARING SET
1022	P04511022	GEAR 30T
1023	PSS01M	SET SCREW M6-1 X 10

REF	PART #	DESCRIPTION
1024	P04511024	BALL BEARING UCFK205
1025	PSB11M	CAP SCREW M8-1.25 X 16
1026	PLW04M	LOCK WASHER 8MM
1027	P0451208	FENDER WASHER 8MM
1028	PR05M	EXT RETAINING RING 15MM
1029	PSB03M	CAP SCREW M5-.8 X 8
1030	P04511030	FREE JOINT
1031	PSB04M	CAP SCREW M6-1 X 10
1032	P04511032	SHAFT
1033	PSB04M	CAP SCREW M6-1 X 10
1034	PW03M	FLAT WASHER 6MM
1035	P04511035	SUPPORT PLATE
1036	P04511036	COLLAR
1037	P04511037	THRST BEARING LFW-2015
1038	P04511038	LOCATE BLOCK
1039	P04511039	BUSHING DU2030
1040	P51104	THRUST BEARING 51104
1041	P04511041	WORM SHAFT
1042	PK25M	KEY 7 X 7 X 20
1043	PSB84M	CAP SCREW M10-1.5 X 35
1044	PSS01M	SET SCREW M6-1 X 10
1045	P04511045	BUSHING DU1515

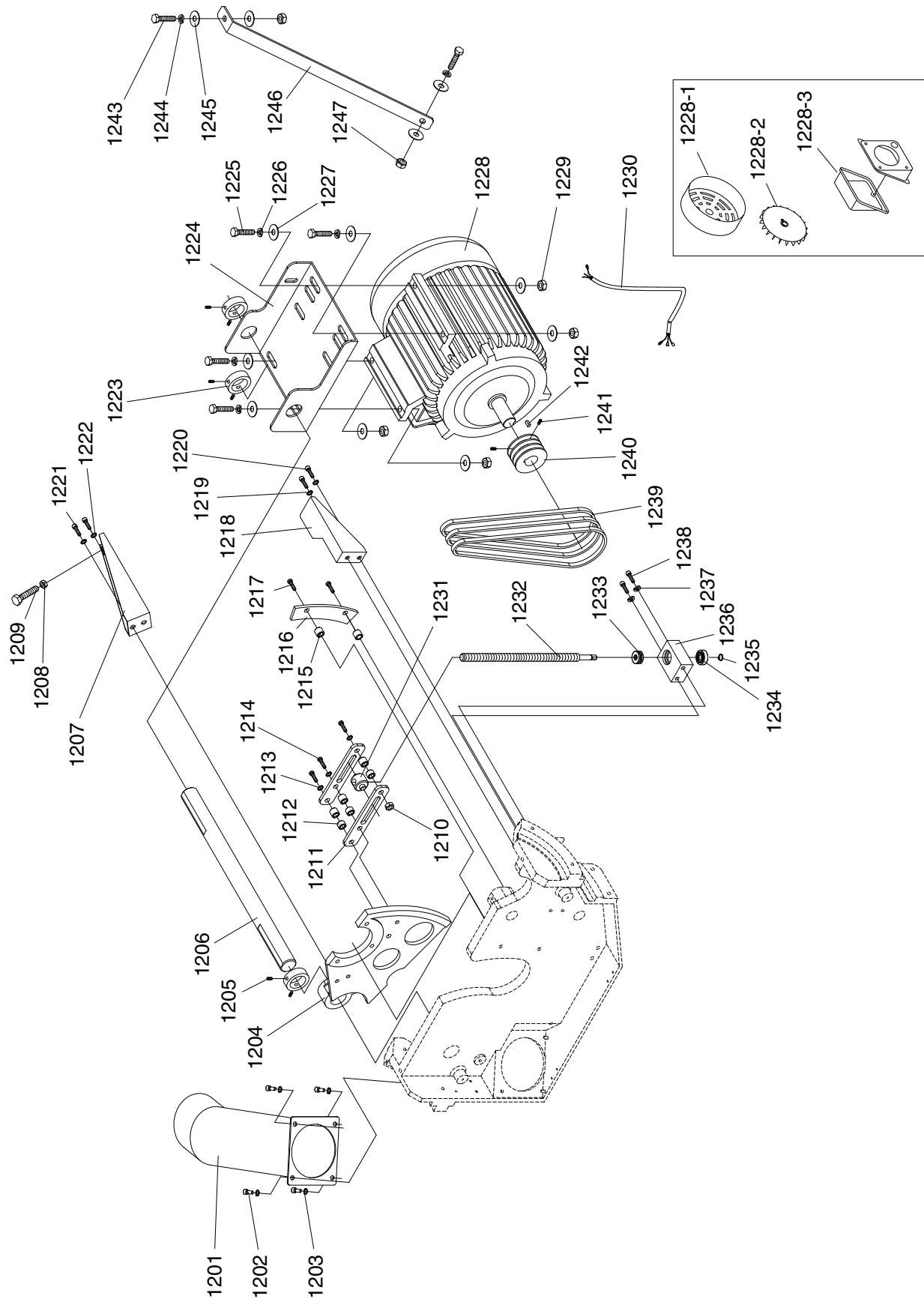
Swing Arm Assembly



REF	PART #	DESCRIPTION
1101	P04511101	NYLON WASHER M10 X 25
1102	P04511102	SUPPORT SHAFT
1103	PN05M	HEX NUT M16-1.5
1104	P04511104	PLUG 100 X 50
1105	PB26M	HEX BOLT M8-1.25 X 30
1106	P04511106	MAGNETIC BRACKET
1107	P04511107	SLIDING TUBE
1108	PB26M	HEX BOLT M8-1.25 X 30
1109	PN03M	HEX NUT M8-1.25
1110	PHTEK7	TAP SCREW #8 X 3/8"
1111	P04511111	COVER
1112	PW01M	FLAT WASHER 8MM
1113	P04511113	ADJUST SHAFT
1114	PR05M	EXT RETAINING RING 15MM
1115	PN03M	HEX NUT M8-1.25

REF	PART #	DESCRIPTION
1116	PSS19M	SET SCREW M8-1.25 X 30
1117	P04511117	ROLLER
1118	P6202	BALL BEARING 6202ZZ
1119	PSS19M	SET SCREW M8-1.25 X 30
1120	PR21M	INT RETAINING RING 35MM
1121	P04511121	SWING ARM
1122	P51102	THRUST BEARING 51102
1123	PB82M	HEX BOLT M8-1.25 X 80
1124	PW01M	FLAT WASHER 8MM
1125	PLN04M	LOCK NUT M8-1.25
1126	P6202	BALL BEARING 6202ZZ
1127	P04511127	BRUSH
1128	PW03M	FLAT WASHER 6MM
1129	PSB02M	CAP SCREW M6-1 X 20

Main Motor Assembly



REF	PART #	DESCRIPTION
1201	P04511201	DUST PORT
1202	PSB52M	CAP SCREW M8-1.25 X 10
1203	PLW04M	LOCK WASHER 8MM
1204	P04511204	ROTATE PLATE
1205	PSS01M	SET SCREW M6-1 X 10
1206	P04511206	SHAFT
1207	P04511207	LOCATE PLATE
1208	PN09M	HEX NUT M12-1.75
1209	PB33M	HEX BOLT M12-1.75 X 50
1210	PN02M	HEX NUT M10-1.5
1211	P04511211	SUPPORT PLATE
1212	P04511212	BUSHING
1213	PLW06M	LOCK WASHER 10MM
1214	PSB134M	CAP SCREW M10-1.5 X 65
1215	P04511215	BUSHING
1216	P04511216	GIB PLATE
1217	PSBS10M	BTN HD SCR M10-1.5 X 25
1218	P04511218	LOCATE PLATE
1219	PLW04M	LOCK WASHER 8MM
1220	PSB11M	CAP SCREW M8-1.25 X 16
1221	PSB130M	CAP SCREW M10-1.5 X 16
1222	PLW06M	LOCK WASHER 10MM
1223	P04511223	COLLAR
1224	P04511224	MAIN MOTOR PLATE
1225	PB31M	HEX BOLT M10-1.5 X 40

REF	PART #	DESCRIPTION
1226	PLW06M	LOCK WASHER 10MM
1227	PW04M	FLAT WASHER 10MM
1228	P04511228	MAIN MOTOR 10HP
1228-1	P04511228-1	FAN COVER
1228-2	P04511228-2	MOTOR FAN
1228-3	P04511228-3	MOTOR WIRING BOX
1229	PN02M	HEX NUT M10-1.5
1230	P04511230	MAIN MOTOR CORD
1231	P04511231	ADJUST BLOCK
1232	P04511232	ELEV SCREW M16-2 X 335
1233	P51200	THRUST BEARING 51200
1234	P6200	BALL BEARING 6200ZZ
1235	PR01M	EXT RETAINING RING 10MM
1236	P04511236	FIX BLOCK
1237	PLW06M	LOCK WASHER 10MM
1238	PSB70M	CAP SCREW M10-1.5 X 45
1239	PVM25	V-BELT M25
1240	P04511240	MAIN MOTOR PULLEY
1241	PSS01M	SET SCREW M6-1 X 10
1242	P04511242	KEY 8 X 7 X 50
1243	PB01M	HEX BOLT M10-1.5 X 30
1244	PLW06M	LOCK WASHER 10MM
1245	PW04M	FLAT WASHER 10MM
1246	P04511246	FIX PLATE
1247	PN02M	HEX NUT M10-1.5

WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.



WARRANTY CARD

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Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. **Of course, all information is strictly confidential.**

1. How did you learn about us?

_____ Advertisement _____ Friend _____ Catalog
_____ Card Deck _____ Website _____ Other: _____

2. Which of the following magazines do you subscribe to?

_____ Cabinet Maker	_____ Popular Mechanics	_____ Today's Homeowner
_____ Family Handyman	_____ Popular Science	_____ Wood
_____ Hand Loader	_____ Popular Woodworking	_____ Wooden Boat
_____ Handy	_____ Practical Homeowner	_____ Woodshop News
_____ Home Shop Machinist	_____ Precision Shooter	_____ Woodsmith
_____ Journal of Light Cont.	_____ Projects in Metal	_____ Woodwork
_____ Live Steam	_____ RC Modeler	_____ Woodworker West
_____ Model Airplane News	_____ Rifle	_____ Woodworker's Journal
_____ Modeltec	_____ Shop Notes	_____ Other: _____
_____ Old House Journal	_____ Shotgun News	

3. What is your annual household income?

_____ \$20,000-\$29,000 _____ \$30,000-\$39,000 _____ \$40,000-\$49,000
_____ \$50,000-\$59,000 _____ \$60,000-\$69,000 _____ \$70,000+

4. What is your age group?

_____ 20-29 _____ 30-39 _____ 40-49
_____ 50-59 _____ 60-69 _____ 70+

5. How long have you been a woodworker/metalworker?

_____ 0-2 Years _____ 2-8 Years _____ 8-20 Years _____ 20+ Years

6. How many of your machines or tools are Grizzly?

_____ 0-2 _____ 3-5 _____ 6-9 _____ 10+

7. Do you think your machine represents a good value?

_____ Yes _____ No

8. Would you recommend Grizzly Industrial to a friend?

_____ Yes _____ No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?

Note: We never use names more than 3 times.

_____ Yes _____ No

10. Comments: _____

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